

SMAW

# AceWeld 308L-16

## For Stainless Steel

CLASSIFICATIONS: AWS A5.4 : E308L-16  
 EN ISO 3581-A : E 19 9 L R 12  
 EN ISO 3581-B : ES308L-16  
 JIS Z 3221 : ES308L-16

WELDING  
 POSITIONS :



- **All Position, Rutile Type Stainless Steel Electrode**
- **Excellent Striking & Restriking Even After Cooling of Electrodes**
- **Low Moisture Pick Up Type Coating**
- **Minimal Spatter & Self-Peeling Slag**

## DESCRIPTION AND APPLICATIONS

**AceWeld 308L-16** is an extra low carbon Rutile austenitic stainless steel electrode exhibiting superior all positional (except vertical down) performance with improved moisture resistance coating, excellent corrosion and scaling resistance.

Soft fusion without spatters, easy slag removed, exceptional bead appearance and easy striking & restriking best suitable for 18/8 type of stainless steels at service temperature from -120°C to +350°C, tubes, stainless steel piping in refineries, chemical plant and other stabilise and non-stabilised 300 series stainless steel.

Other features include high arc stability and easy restriking even at low voltage AC welding machine.

## TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	Cr	Ni	S	P
0.025	0.7	0.8	18.5	9.1	0.015	0.025

## TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
460 N/mm <sup>2</sup>	585 N/mm <sup>2</sup>	40%	68J @ +20°C

## OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE(amps.)	PACKAGING (KG)	
			PKT	CTN
1.6	300	30 - 45	2.5	20
2.0	300	45 - 55	2.5	20
2.6	300	50 - 80	2.5	20
3.2	350	70 - 100	2.5	20
4.0	350	100 - 140	2.5	20
5.0	350	140 - 170	2.5	20

- Recommended for DC+ or AC (minimum 55 OCV) operation.
- Available in 1 KG packaging.
- Re-dry electrode at 300°C - 350°C for 1 hour if necessary
- Also available in: Solid Mig Wire : MIG MC-308LSi, Tig Rod : TIG MC-308L/LSi, Flux Cored Wire : COREMAX 308LP