SMAW

AceWeld 308L-17

For Stainless Steel

CLASSIFICATIONS:

AWS A5.4	: E308L-17
EN ISO 3581-A	: E 19 9 L R 12
EN ISO 3581-B	: ES308L-17
JIS Z 3221	: ES308L-17

WELDING POSITIONS :

- **All Position, Rutile Silica Type Stainless Steel Electrode**
- **Excellent Striking and Restriking Even After Cooling of Electrode**
- **Allow Much Higher Welding Current Than L-16 Type Electrode**

DESCRIPTION AND APPLICATIONS

AceWeld 308L-17 is an extra low carbon Rutile silica austenitic stainless steel electrode exhibiting superior all positional (except vertical down) performance with improved moisture resistance coating, excellent corrosion, scaling resistance and controlled ferrite appro 6-8%.

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 tank, 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	0.8	0.9	19.0	9.5	0.015	0.025

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
470 N/mm^2	610 N/mm^2	38%	70J @ +20°C

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE(amps.)	PACKAGING (KG)	
			PKT	CTN
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

- 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