

SMAW

Filler PRO 308L-17 Filler PRO 309L-17 Filler PRO 316L-17

for Stainless Steel

CLASSIFICATIONS: AWS A5.4 : E308L-17
EN ISO 3581 : E 19 9 L R 12

CLASSIFICATIONS: AWS A5.4 : E309L-17
EN ISO 3581 : E 23 12 L R 12

CLASSIFICATIONS: AWS A5.4 : E316L-17
EN ISO 3581 : E 19 12 3 L R 12

WELDING POSITIONS :



- All Position, Rutile Silica Type Stainless Steel Electrode
- Excellent All Position Weldability
- Excellent Striking & Restriking Even After Cooling of Electrodes
- Very Stable Arc With Low Spatter
- Allow Much Higher Welding Current Than L-16 Type Electrode
- Superior Arc Transfer Better Than L-16 Electrodes
- Excellent On Low OCV AC/DC+ Power Source

DESCRIPTION AND APPLICATIONS

Filler PRO 308L-17 for welding stainless steel grade 301,302,304,304L,308,308L.

Filler PRO 309L-17 for welding stainless steel grade 309,309L,301,302,304,304L,308,308L and welding of dissimilar steels such as Cr-Mo steel or carbon steel to stainless steel.

Filler PRO 316L-17 for welding stainless steel grades 316,316L.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

	C	Mn	Si	Cr	Ni	Mo	S	P
Filler PRO 308L-17	0.03	0.80	0.90	19.0	9.50	0.10	0.010	0.015
Filler PRO 309L-17	0.03	0.90	0.90	23.80	12.80	0.10	0.012	0.015
Filler PRO 316L-17	0.023	0.70	0.85	18.80	12.05	2.60	0.015	0.012

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

	YIELD STRENGTH	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
Filler PRO 308L-17	440MPa	590MPa	38%	60J @ -20°C
Filler PRO 309L-17	460MPa	605MPa	36%	60J @ +20°C
Filler PRO 316L-17	420MPa	600MPa	40%	75J @ -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 - 85	2.5	20
3.2	350	70 - 110	2.5	20
4.0	350	100 - 150	2.5	20

- Recommended for DC+ or AC (minimum 55 OCV) operation.
- Also available in 1 KG packaging.
- Re-dry electrode at 300°C - 350°C for 1 hour if necessary.