

Stainless Steel SMAW Electrodes

G308L

AWS A5.4 E308L-16
JIS Z 3221 ES308L-16
ISO 3581-A-E 19 9 L R

- Low carbon lime Titanium oxide type covered electrode for low carbon content stainless steel.
- Good arc stability, easy slag removal and less spatter loss.
- Good bead appearance, crack resistance and corrosion resistance.

Applications:

- Suitable for welding of low carbon content 18Cr-8Ni stainless steel such as SUS304 and 304L.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.02	0.69	0.74	10.2	18.8	0.09	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-196°C) J
429	563	48	33

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.0/250	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	30~55	60~85	85~120	115~150	150~200
Vertical / overhead position	30~50	50~70	75~105	95~130	----

Note:

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