

Stainless Steel SMAW Electrodes

G308L-15

AWS A5.4 E308L-15
JIS Z 3221 ES308L-15
ISO 3581-A-E 19 9 L B 4 2

Product Features:

- Basic coating of stainless steel electrodes has outstanding welding performance for vertical and overhead position.
- Austenite weld metal contains adequate ferrite to obtain a balance of both crack and corrosive resistance.

Applications:

- Welding of low carbon content 18Cr-8Ni stainless steel such SUS 304 and 304L.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Cu	Fe
0.04	0.28	1.51	9.9	18.5	0.02	0.04	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-196°C) J
460	593	47	30

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

Diameter / Length	2.6/300	3.2/350	4.0/400	5.0/350
Flat position	60~85	85~110	115~140	150~190
Vertical / overhead position	50~75	75~100	95~130	----

Note:

- 250~300°C x 1hr baking prior to use.

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