

PermaWeld

STAINLESS STEEL WELDING ELECTRODE

AWS E308L-16

DESCRIPTION:

- a. LY E308L-16 is a line titanium type welding electrode for extra-low carbon stainless steel. The weld metal has excellent mechanical properties and shows good resistance to intergranular corrosion due to the carbon content in it is $\leq 0.04\%$.
- b. It can be used for all position welding with excellent performance: stable arc, small spatters, good appearance of weld. And also the welding electrode shows good heat-resistance character, not easy to turn red and gas porosity is not produced.

APPLICATION:

It is suitable for welding structures fabricated by extra-low carbon 022Cr-19Ni10 stainless steel, such as synthetic fibre, fertilizer, petrochemical equipment, etc

ATTENTION:

- a. Before welding, the welding electrodes should be baked at the temperature of 300-350°C for one hour.
- b. Using stainless steel brush to clean the weld seam, in order to avoid scrap iron entering and affect its quality.

Chemical Composition of Deposited Metal: (%)

	C	Mn	Si	P	S	Cr	Ni
Standard	0.033	0.90	0.65	0.020	0.010	19.20	9.65
Typical	≤ 0.04	0.5-2.5	≤ 0.90	≤ 0.040	≤ 0.030	18.0-21.0	9.0-11.0

Mechanical Properties of Deposited Metal

	Tensile Strength σ_b (Mpa)	Elongation 65 (%)
Standard	580	45
Typical	≥ 520	≥ 35

Recommended Current(AC or DC*)

Size(mm)	$\Phi 2.5 \times 350$	$\Phi 3.2 \times 350$	$\Phi 4.0 \times 400$	$\Phi 5.0 \times 400$
Flat Current(A)	50-85	80-120	100-150	140-180
Vertical, Overhead Current(A)	45-80	70-110	90-135	-