RATNA 308L

Low Carbon Stainless Steel Electrode Welding For Maximum Resistance to Corrosion

CLASSIFICATION : AWS/SFA-5.4: E 308L-16; IS-5206: E 19.9LR 26

APPROVAL : LR, RDSO (Class M2), NPCIL

CHARACTERISTICS : An extra low carbon 19/10 stainless steel electrode with properties like resistance to oxidation, resistance to cracking at high temperature. The extra low carbon decreases the possibility of intra-granular corrosion. The electrode gives smooth arc, fine bead appearance and shiny finish.

APPLICATION :

1) Suitable for joining AISI 301L, 302L, 304L and 308L steel having 18Cr/8Ni with low carbon content.
2) Welding for clad steels of similar composition.
3) Overlays in Un-alloyed, low alloy steels etc.

RE-DRY CONDITION : Re-Dry the electrode at 250°C for 1 hrs. Before use

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Cu	Mo
0.04	0.50-2.50	1.00	0.030	0.040	18.0-21.0	9.0-11.0	0.75	0.75

(Single value maximum)

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm^2)	ELONGATION %	CHARPY "V" NOTCH IMPACT AT
520 min	30 min	$+20^0$C : 100 Joules

DIEMENSION, CURRENT CONDITION & PACKING DATA:

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/AC) Amps	Kg./Pkt.	Kg./Case
2.40/2.50	3/32"	50-80	2	10
3.15/3.20	1/8"	75-100	2	10
4.00	5/32"	110-140	2	10
5.00	3/16"	150-180	2	10

Tailor made packing available on request