

ES 308L-15

Type Basic

SMAW
E308L-15

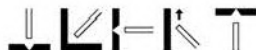
ESWECO
The Art of Welding

Description

ES 308L-15 is a basic, low-carbon, stainless electrode of the E308L type with very good welding properties in the vertical and overhead positions. The high impact toughness at cryogenic temperature (-196°C) makes ES 308L-15 excellent in LNG applications.

Current

DC+



Classifications

EN 1600	E 19 9 L B 2 2
SFA/AWS A5.4	E308L-15
Werkstoff Nr.	1.4316

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.04	0.5	1.7	19	10.0	<0.3	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	460
Tensile strength, MPa	580
Elongation A4, %	60

Charpy V

Test temps, °C	Impact values, J
+20	100
-120	70
-196	>32

Ferrite content FN 2-7

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	55-85	22
3.2	350	75-110	25
4.0	350	110-155	27