

ES 308L-16

Type Acid rutile

SMAW

E308L-16

ESWECO
The Art of Welding

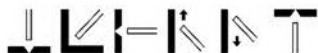
Description

Rutile coated electrode for welding 19Cr10Ni-type steels. Also suitable for welding stabilised steels of similar composition, except when the full creep resistance of the base material is to be met. The electrode is specially designed for welding thin-walled pipes.

ES308L-16's characteristics make this electrode the smart choice for general structural welding, as well as for food, and pharmaceutical equipment applications.

Current

DC+, AC OCV 50 V



Classifications

EN 1600	E 19 9 L R 1 2
SFA/AWS A5.4	E308L-16
Werkstoffnr	1.4316

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.7	0.9	19.5	10.0	<0.5	<0.5

Typical mech. Properties all weld metal

Yield stress, MPa	430
Tensile strength, MPa	560
Elongation A4, %	45

Charpy V

Test temps, °C	Impact values, J
+20	70
Ferrite content	FN 3-10

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	60-90	31
3.2	350	70-120	31
4.0	350	90-170	32