

S-308.16N

Type : Rutile

Conformances

AWS A5.4/ ASME SFA5.4 E308-16
 JIS Z3221 ES308-16
 EN ISO 3581-A-E 19 9 R
 KR RD308
 ABS AWS A5.4 E308-16
 DNV·GL NV 308

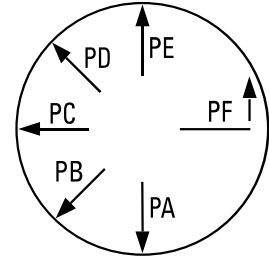
Applications

- Stainless steel (18%Cr-8%Ni)

Features

- Good resistance to corrosion and oxidizing environments
- Easy to remove slag
- Low spatter
- Good bead appearance

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter	Length	P.V.C	
		packet	carton
mm (in)	mm (in)	2.5kg(5.5lbs)	10kg(22lbs)
2.6 (3/32)	350 (14)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	
6.0 (15/64)	450 (18)	✓	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni
0.03	0.66	0.87	0.026	0.014	19.2	10.2

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
562 (81,600)	47.8

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F & HF	25~55	50~85	70~115	95~145	135~180
V-up, OH	20~50	45~80	65~110	85~135	-

SMW

SAW

GMW

GTW

FCW

Non-FERROUS

APPENDIX