S-308L.16N[17]

Type : Rutile, Rutile-acid

CE

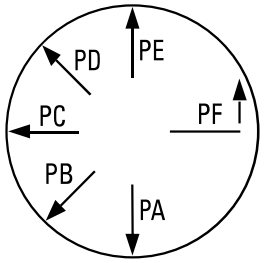
Conformances

AWS	A5.4/ ASME SFA5.4 E308L-16
JIS	Z3221 ES308L-16 / EN ISO 3581-A-E 19 9 L R
AWS	A5.4 / ASME SFA5.4 E308L-17
JIS	Z3221 ES308L-17 / EN ISO 3581-A-E 19 9 L R
KR	RD308L
ABS	AWS A5.4 E308L-16
	AWS A5.4 E308L-17
LR	304L
BV	308L
DNV·GL	NV 308L
NK	KD308L
CWB	CSA W48 E308L-16
TÜV	EN ISO 3581-A - E 19 9 L
DB	DIN EN ISO 3581-A-E 19 9 L R
CE	
CCS	304L

Applications

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

Welding Position



Features

- Good resistance to corrosion and oxidizing environments
- Easy to remove slag
- Good bead appearance
- High moisture resistance (17 type)

Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter	Length	Standard		Vacuum				P.V.C	
mm (in)	mm (in)	packet	carton	packet	carton	packet	carton	packet	carton
		5kg(11lbs)	20kg(44lbs)	1.5kg(3.3lbs)	15kg(3.3lbs)	5kg(11lbs)	20kg(44lbs)	2.5kg(11lbs)	10kg(22lbs)
2.0 (5/64)	300 (12)							√	
2.6 (3/32)	300 (12)							√	
3.2 (1/8)	350 (14)							√	
4.0 (5/32)	350 (14)							√	
5.0 (3/16)	350 (14)							√	

Typical Chemical Composition of All-Weld Metal (%)

Product name	C	Si	Mn	P	S	Cr	Ni
S-308L.16N	0.02	0.67	0.87	0.028	0.018	19.2	10.0
S-308L.17	0.02	0.63	0.98	0.028	0.017	19.0	9.9

Typical Mechanical Properties of All-Weld Metal

Product name	TS MPa(lbs/in²)	EL (%)
S-308L.16N	561 (81,500)	44.0
S-308L.17	570 (82,800)	49.0

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	-