

Product Data Sheet

Stainless steel Rutile type electrode

SUPER OPTIMAL 308L-17

Classification

AWS A5.4 : E 308L-17

DIN EN ISO 3581-A : E 19 9 LR 12

DIN EN 1600: E 19 9 LR 12

Werkstoff Nr: 1.4316

Description and applications

Low carbon Rutile-silica-coated 19Cr, 10Ni austenitic stainless steel electrode with controlled ferrite approx 6-8% for maximum resistance to cracking and corrosion. Core wire is 308LER. Coating with very low moisture pick up. Soft fusion without spatters, very easy slag removal exceptional weld bead appearance, easy restriking. Applied for all 18/8type stainless steels at service temperature from - 120°C upto + 350°C tubes, tanks, heat exchangers, piping systems.....

Packed in vacpack system.

Base materials

Stainless steels for general use:				
UNS	Alloy	EN 10088	Material N ^a	UGINE
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B, D, E
S30403	304L	X2CrNi19-11	1.4306	UGINOX 18-10 T
S30800	308	X2CrNi18-10	1.4300	UGINOX 19- 11 B, D, E
S30803	308 L	X2CrNi 19-11	1.4300	UGINOX 19-11 B,D,E
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb18-10	1.4550	

Typical Weld Metal Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	S	P
0.03	0.90	0.80	19.0	9.50	0.10	0.010	0.025

All weld metal Mechanical Properties (Typical)

Tensile Strength R _m (N/mm ²)	Elongation A ₅ (%)	Charpy Impact value (ISO-V J RT)
610	38	60

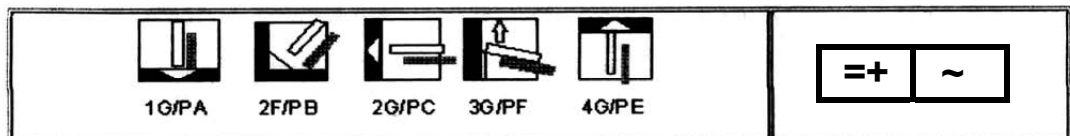
Amperes (A)

2.50mm	3.15mm	4.00mm	5.00mm
50-80	70- 100	100- 140	140- 170

Welding instruction

Keep dry and avoid condensation.Re-dry generally not required, if necessary redry electrodes at 300-350°C for 1hr. Interpass temperature :< 200°C.

Welding Position



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