



## STAINLESS STEEL WELDING ELECTRODES

# RASI E 308L-16

### TECHNICAL SPECIFICATION SHEET



#### CHARACTERISTICS

An extra-low carbon 19/10 SS electrode with controlled Ferrite content for maximum resistance to cracking, corrosion and high temperatures. The Weld metal has excellent creep strength and is of radiographic quality. Excellent arc stability and low spatter loss. All sizes strike and re-strike easily. The slag is easily controlled and does not interfere with the arc action. Weld beads are smooth, uniform and of excellent appearance.

#### APPLICATIONS

Welding of Stainless Steels of AISI 301, 302, 304 and 308. Used for Hospital Equipments, Air Crafts Frames, Drugs and Pharmaceutical equipments, Apparatus for Nitric Acid, Acetic Acid, Milk, Soap and Fertilizer Industries etc.

#### CLASSIFICATIONS

IS 5206 : E19.9LR26  
AWS/ SFA : E 308-16

#### CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.04%	Silicon - 0.30 - 0.85%
Manganese - 0.60 - 2.0%	Sulfur - 0.03%
Phosphorus - 0.04%	Cr - 18 - 22%
Ni - 9 - 11%	

Note: Single Values shown above are maximum

#### MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (MPa) - 530 - 650  
ELONGATION (L=4d) - 35 - 40

#### WELDING CURRENT : AC, DC(±)

Ø 2.00 mm - 35 - 45 Amps  
Ø 2.50 mm - 50 - 75 Amps  
Ø 3.15 mm - 80 - 100 Amps  
Ø 4.00 mm - 110 - 140 Amps

**\*FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- [info@rasielectrodes.com](mailto:info@rasielectrodes.com)**

storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

\*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

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