

**AFROX 308L**



Afrox 308L is a rutile basic coated low carbon electrode of the high quality welding of stainless steel of the 19% chromium and 9% nickel type. It is recommended for welding AISI 302, 304, 304L, 321 and 347 stainless steels, which may be used in the following applications: brewing equipment, steam piping, vacuum pump parts, dairy equipment, textile drying equipment, chemical handling equipment, pharmaceutical and food processing.

**CLASSIFICATIONS**

AWS	A5.4	E308L-17
SABS	1293	E19.9.LR 26
BS EN	1600	E 19 9 LR

**APPROVALS**

TUV (Kenblatt number 3242.00)  
 South African Bureau of Standards (SABS 1293 and ISO 9001).

**CHEMICAL ANALYSIS**

% Carbon	0.03 max	% Nickel	9.0 - 11.0
% Manganese	0.5 - 2.5	% Sulphur	0.025 max
% Silicon	0.90 max	% Phosphorous	0.025 max
% Chromium	18.0 - 21.0		

**TYPICAL MECHANICAL PROPERTIES  
 (ALL WELD METAL IN THE AS WELDED  
 CONDITION)**

0,2% Proof Stress	400 MPa min
Tensile Strength	520 - 630 MPa
% Elongation on 4D	35 min
Charpy V-Notch at +20°C	50J min
Charpy V-Notch at -70°C	40J min
Charpy V-Notch at 1-196°C	25J min
Hardness VPN	180 - 220

**PACKING DATA**

(DC + AC 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current Amps	Item Number 1Kg Electrode Pack	Item Number Multi-Kg pack	Pack Mass (Kg)
2.5	300	40 - 80	072-701	075-702	3 x 4
3.25	350	70 - 105	072-703	075-703	3 x 4
4	350	90 - 145	-	075-704	3 x 4

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre,  
 tel: 0860 020202 or e-mail: customer.service@afrox.boc.com  
 Website: www.afrox.com

