

**AFROX 308L Class C5 Schedule K**



Afrox 308L Class C5 Schedule K is a rutile basic coated low carbon electrode for welding 19% Cr 9% Ni type stainless steel, it has been specially formulated for applications requiring low temperature properties at -90°C for use in cryogenic applications. It is batch tested for tensile, charpy impact values and lateral expansion at -90°C.

**CLASSIFICATION**

AWS	A5.4	E308L-17
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**CHEMICAL ANALYSIS (TYPICAL)**

% Carbon	0.023	% Chromium	19.200
% Manganese	0.543	% Molybdenum	0.127
% Silicon	0.677	% Nickel	9.770
% Sulphur	0.010	% Copper	0.040
% Phosphorous	0.010		

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

	AC	DC
2% Proof Stress	486 MPa	480 MPa
Tensile Strength	619 MPa	617 MPa
Elongation %	47.7%	44.7%
Charpy V-Notch at -90°C	39J	39J
Lateral Expansion	0.30 mm	0.29 mm
Moisture Content	0.125%	0.125%

**PACKING DATA**

Diameter (mm)	Electrode Length (mm)	Amps	Item Number	Pack Mass (Kg)
2.5	350	40 - 80	087-702	3 x 4
3.2	350	70 - 105	087-703	3 x 4
4.0	350	90 - 145	087-704	3 x 4

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