

**SUPERWELD 308L**



SUPERWELD 308L is a rutile basic coated low carbon electrode for the 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-16
BS EN	1600	E 19 9 LR12

**CHEMICAL ANALYSIS**

% Carbon	0.03	% Nickel	9.90
% Manganese	1.30	% Sulphur	0.008
% Silicon	0.35	% Phosphorous	0.014
% Chromium	19.38		

**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 I-196°C	25J min
Hardness VPN	180 - 220

**PACKING DATA**

(DC + AC 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current Amps	Item Number Multi-Kg pack	Pack Mass (Kg)
2.5	300	50 - 85	085-702	3 x 5
3.25	350	80 - 120	085-703	3 x 5
4	350	100 - 150	085-704	3 x 5

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