ESAB 308L PLUS

ESAB 308L Plus is a rutile based stainless steel electrode for welding of 18Cr-8Ni austenitic stainless steel with low carbon.

Specifications	
Classifications	SFA/AWS A5.4 : E308L-16

Welding Current	AC, DC+
Ferrite Content	3-10 FN
Alloy Type	Austenitic Cr-Ni
Coating Type	Rutile

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	440 MPa	580 MPa	45 %

Typical Weld Metal Analysis %								
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**
0.02	0.65	0.75	0.015	0.022	9.70	18.80	0.04	0.05

Deposition Data	
Diameter	**Current**
2.5 x 350.0 mm	40-70 A
3.15 x 350.0 mm	60-100 A
4.0 x 350.0 mm	80-140 A