

## 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

|                        |                         |
|------------------------|-------------------------|
| <b>Classifications</b> | SFA/AWS A5.4 : E308L-16 |
| <b>Welding Current</b> | AC, DC+                 |
| <b>Ferrite Content</b> | 3-10 FN                 |
| <b>Alloy Type</b>      | Austenitic Cr-Ni        |
| <b>Coating Type</b>    | Rutile                  |

### Typical Tensile Properties

| Condition  | Yield Strength | Tensile Strength | Elongation |
|------------|----------------|------------------|------------|
| <b>AWS</b> |                |                  |            |
| 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 |