

ESL'ARC - 308L



Classification

Class -

IS : 5206 - 03 : E19.9LR26

AWS -

E308L

Application

For fabrication of stainless steel type 3 Cr 12, IRS M-44 or its equivalent, welding of AISI 301, 302, 304, 308, 308L grades of stainless steel

Characteristics

Rutile coated extra low carbon stainless steel electrode that is suitable for fabrication of 18 % Cr, 8% Ni, stainless steel with low carbon and similar grades. The electrode runs on both AC & DC power sources giving smooth weld beads and a self-peeling slag.

Welding Current (AMPS) AC or DC (D+A70V)

5.00X350mm	4.00X350mm	3.15X350mm	2.50X350mm
150-200	120 -150	90 -120	60-90

Weld Metal Analysis (Average Value) :

C%	Mn.%	Si%	S%	P%	Ni%	Cr%	Mo%
0.04 Max	2.50 Max	0.90 Max	0.03 Max	0.04 Max	8-11	18-21	0.50 Max

Mechanical Properties of Weld Metal (Average Value):

UTS	Elongation L = 5.65√A
570 N/mm ² min	40% min



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