MIDALLOY CHROMAX E308L-16 COATED ELECTRODE

CLASSIFICATION

- AWS 5.4 Class E308L-16 / ASME SFA 5.4 Class E308L-16 / ASME Sec. IX, F4, A8

DESCRIPTION

- MIDALLOY CHROMAX E308L-16 is AC-DC titania coated electrode (UNS W30813). Provides a smooth and stable arc with easy slag removal, complete penetration and excellent bead appearance.

APPLICATION

- For welding of various stainless steel which include AISI Types 301,302,304,304L and 305. The low carbon content of these electrodes reduces the possibilities carbide precipitation thus increasing the resistance to inter-granular corrosion. This electrode is used to weld plate, pipe, fitting, castings and all product forms with a composition of 18Cr-8 Ni (i.e. type 304 and 304L).

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
0.03	19.7	10.3	.03	.80	.60	.020	.010	.10	.06

FERRITE CONTENT 5-15 WRC 1992

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	84,500 PSI
YIELD STRENGTH	55,000 PSI
ELONGATION IN 2”	40%

RECOMMENDED WELDING PARAMETERS

DIAMETER	AMPERAGE	
	FLAT	VERTICAL & OVERHEAD
3/32”	70-85	65-75
1/8”	85-110	80-90
5/32”	110-140	100-120
3/16”	120-160	110-130

STANDARD PACKAGING

- 3/32”- 8 lb. Can, 48 lb. Carton
- 1/8”, 5/32”, 3/16” - 10 lb. Can, 60 lb. box

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