

# EI 308LRS

Coated Electrode for Stainless Steels -

Standards	
AWS/ASME SFA - 5.4	E308L-17
EN ISO 3581 - A	E 19 9 L R 12
TS EN ISO 3581 - A	E 19 9 L R 12
DIN M. No.	1.4316

Materials		
EN	Material	ASTM
X5CrNi18-10	1.4301	304
X4CrNi18-12	1.4303	305
X2CrNi19-11	1.4306	304L
GX5 Cr Ni 19 10	1.4308	CF-8
X2CrNiN 18-10	1.4311	304LN
X6CrNiTi18-10	1.4541	321
X6CrNiNb18-10	1.4550	347, 347H
GX5CrNiNb 19-11	1.4552	

## Properties and Applications

Rutile type electrode for welding austenitic stainless Cr-Ni steels or cast steels, having an extra low carbon content, as well as stainless or heat resisting chromium steels or cast steels. Suitable for welding stainless steel tanks, valves, pipes and linings in chemical, food, beverage, pharmaceutical industries. For operating temperatures of up to 350°C, non-scaling up to 800°C. Possible to use equally well both with AC and DC. Easy arc striking and re-striking. Fine metal droplet transfer, good fusion of joint faces, very finely rippled, flat and smooth bead surface especially in fillet welds, easily removable slag.



## Typical Chemical Values of Weld Metal

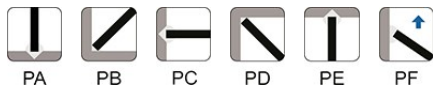
Type of Analysis	C	Si	Mn	Cr	Ni
Weld Deposit	0.02	0.70	0.90	19.50	10.00

## Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	440	570	42	20°C → 70

## Application Information

### Welding Positions



### Polarity:



### Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
4.00x350	100-165
3.25x350	80-120
2.50x300	50-80

## Packaging Information

Product Code	Diameter X Length (mm)	Pieces per Box (-)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
13005GJEM2	2.50x300	95 kg	1.8	10	18.5	VAC Box

13005NJEM2	3.25x350	56 kg	2.0	10	21.0	VAC Box
13005QJEM2	4.00x350	36 kg	2.0	10	20.8	VAC Box

#### Storage & Re-Drying Information

It can be dried maximum 5 times.  
It has to be dried at 350°C for 2 hours.