

Ratna E 308L

CLASSIFICATION

- AWS/SFA-5.4 E 308L-16
- IS-5206 E 19.9LR 26

APPLICATIONS

- Suitable for joining AISI 301L, 302L, 304L and 308L steel having 18Cr/8Ni with low carbon content.
- Welding for clad steels of similar composition.
- Overlays in un-alloyed, low alloy steels etc.

DESCRIPTION

- An extra low carbon 19/10 stainless steel electrode with properties like resistance to oxidation, resistance to cracking at high temperature. The extra low carbon decreases the possibility of intra-granular corrosion. The electrode gives smooth arc, fine bead appearance and shiny finish.

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)

CARBON (C)	MAGNESIUM (MN)	SILICON (SI)	SULFUR (S)	PHOSPHORUS (P)	CHROMIUM (CR)	NICKEL (NI)	COPPER (CU)	MOLYBDENUM (MO)
0.040	0.50-2.50	1.00	0.030	0.040	18.0-21.0	9.00-11.00	0.75	0.75

CURRENT POLARITY

DC(+), AC

WELDING POSITION

FLAT, HORIZONTAL, VERTICAL, OVERHEAD

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)

YIELD STRENGTH (N/MM ²) KSI	ULTIMATE TENSILE STRENGTH (N/MM ²) KSI	ELONGATION (%)	CVN IMPACT AT °C JOULES
-	520 MIN	30 MIN	+20°C :100 J

SIZE AND CURRENT RECOMMENDATIONS

SIZE D X L (MM)	SIZE D X L (IN)	CURRENT (AMPS) DC+, AC
2.5mm x 350mm	3/32" x 14"	50-80
3.2mm x 350mm	1/8" x 14"	75-100
4.0mm x 350mm	5/32" x 14"	110-140

RE-DRY CONDITIONS

- Re-dry the electrode at 250°C for 1 hour.

NOTE:
THE INFORMATION PROVIDED IN THIS ARTICLE OR OTHERWISE REFERRED TO HEREIN IS MERELY PROVIDED AS "TYPICAL" WITHOUT ANY ASSURANCE OR PROMISE. ACTUAL RESULTS WILL VARY BASED ON A NUMBER OF VARIABLES, INCLUDING, BUT NOT LIMITED TO, WELD PROCESS, PLATE CHEMISTRY AND TEMPERATURE, WELDMENT DESIGN, AND FABRICATION PROCEDURES. WASHINGTON CENTRAL CORPORATION EXPRESSLY DISCLAIMS ANY LIABILITY SUFFERED FROM ANY RELIANCE THEREON. IT IS ADVISED THAT BEFORE USING ANY WELDING CONSUMABLE OR PROCEDURE IN THE INTENDED APPLICATION, USERS CHECK THEIR COMPATIBILITY THROUGH QUALIFICATION TESTING OR OTHER SUITABLE METHODS.