

## Stick electrode

**Features:** • Applicable for 304L type steel

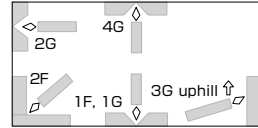
**Classification:** AWS A5.4 E308L-16

**Redrying Conditions:** 150~200°Cx0.5~1h

**Identification color:** 1st Red

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.0	250	2	20	11	300W, 125H, 280L
2.6	300	2	20	20	300W, 100H, 330L
3.2	350	5	20	36	175W, 115H, 380L
4.0	350	5	20	55	175W, 130H, 380L
5.0	350	5	20	82	175W, 130H, 380L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.03	0.04
<b>Si</b>	0.38	1.00
<b>Mn</b>	1.5	0.5~2.5
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	9.6	9.0~11.0
<b>Cr</b>	20.3	18.0~21.0
<b>Mo</b>	0.14	0.75
<b>Cu</b>	0.05	0.75

Note: <sup>a</sup>Single values are maximum.

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.0	50~75	45~65
2.6	75~95	70~90
3.2	85~120	80~115
4.0	110~160	90~140
5.0	150~200	-

## All-weld mechanical properties

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	410	-
<b>TS (MPa)</b>	580	518min.
<b>El on 4d (%)</b>	48	30min.
<b>IV 0°C (J)</b>	78	-

## Approvals

<b>LR</b>	304L m (Chem.)
<b>BV</b>	UP (E308L-16)
<b>NK</b>	KD308L
<b>GL</b>	4306