

EASYARC™ 308L**CLASSIFICATION**

AWS A5.4 E308L-16

GB/T 983 E308L-16

EN1600 E19 9 L R

CHARACTERISTICS & APPLICATIONS

- Excellent weldability, easy slag release, nice bead appearance and good for all position welding;
- Low carbon content in weld metal, better resistant to corrosion;
- Intended for welding of 18%Cr-8%Ni (AISI 304, 304L) stainless steels, as well as 19.5%Cr-10%Ni (AISI 347, 347L) stainless steels.

DIAMETERS / PACKAGING

Diameter × Length (mm × mm)	Standard Package - Weight (kg)*	
	Inner Plastic Box	Outer Master Carton
2.0 x 300	1	20
2.6 x 300	2	24
3.2 x 350	5	20
4.0 x 350	5	20
5.0 x 350	5	20

* PERMAPACK™ (Vacuum sealed package) is also available on request.

ALL WELD METAL MECHANICAL PROPERTIES, TYPICAL VOLUME

Electrode	Condition	Yield Strength Rp0.2 (MPa)	Tensile Strength Rm (Mpa)	Elongation A5 (%)	CVN Impact Strength		
					0°C	-20°C	-40°C
AWS E308L-16	As-welded	—	≥520	≥35	—	—	—
GB E308L-16	As-welded	—	≥520	≥35	—	—	—
EN1600 E 19 9 L R	As-welded	≥320	≥510	≥30	—	—	—
EASYARC™ 308L	As-welded	440	595	37	—	—	—

UNDILUTED WELD METAL CHEMICAL COMPOSITIONS, TYPICAL (Wt-%)

Electrode	C	Cr	Ni	Mo	Mn	Si	P	S	Cu
AWS E308L-16	≤0.04	18.0-21.0	9.0-11.0	≤0.75	0.5-2.5	≤1.00	≤0.040	≤0.030	≤0.75
GB E308L-16	≤0.04	18.0-21.0	9.0-11.0	≤0.75	0.5-2.5	≤0.90	≤0.040	≤0.030	≤0.75
EN1600 E 19 9 L R	≤0.04	18.0-21.0	9.0-11.0	—	≤2.0	≤1.20	≤0.030	≤0.025	—
EASYARC™ 308L	0.026	19.81	10.10	0.0078	0.99	0.72	0.022	0.005	0.0028

RECOMMENDED WELDING PARAMETERS (CURRENT POLARITY: AC & DC+)

Diameter × Length (mm × mm)	Welding Position	2.0 x 300	2.5 x 300	3.2 x 350	4.0 x 350	5.0 x 350
Current (A)	1G, 2G, 2F	35-55	50-85	80-120	100-150	140-200
	3G up, 4G	30-50	45-85	70-110	90-135	—

Customer Assistance Policy

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