

BÖHLER AWS E308L-17

High alloyed stick electrode type 308L for welding of austenitic stainless steel like 1.4301 or 1.4306 or AISI 304L



Main benefit

Core wire alloyed stick electrode for very homogeneous corrosion resistance.

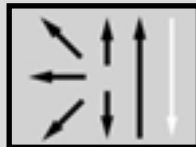

| Product features | Product benefits | User benefits |
|--|--|--|
| » Core wire alloyed coating concept | » Homogeneous chemistry of every single stick from the beginning up to the end | » Homogeneous weld seams lead to reliable corrosion resistance |
| » Designed for easy welding | » Minimum spatter formation » Self-releasing slag | » Less post weld cleaning » Lower total welding time |
| » Rutile coated | » Easy to handle » Very good welding characteristics | » Fine ripped weld seams » Shiny surface for visible seams |
| » Designed for high quality welds | » Very good mechanical properties | » Welding for high demanding industries |



Typical applications

- » Chemical industry
- » Food and beverage industry
- » Storage tanks
- » Stainless steel parts for buildings

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| Classifications | | Operating data | |
|-----------------|--------------------|--|---|
| EN ISO 3581-A | AWS A5.4 / SFA-5.4 | Welding positions | Polarity |
| E 19 9 LR 3 2 | E308L-17 |  |  |

| Typical analysis of all weld metal, wt. % | | | | | |
|---|------|------|------|-------|------|
| | C | Si | Mn | Cr | Ni |
| | 0.03 | 0.80 | 0.80 | 19.80 | 10.2 |

| Mechanical properties, all weld metal (single values typical) | | | | | | | |
|---|--------------------------------|---------------------------------------|----------------------------------|---------------------------------------|------------------------------------|---------|-----------|
| | Condition | Yield strength $R_{p0.2\%}$ MPa | Tensile strength R_m MPa | Elongation A ($L_0 = 5d_0$) % | CVN Impact toughness ISO-V KV J | | |
| | | | | | 20 °C | -120 °C | -196 °C |
| | As welded | 430 (≥ 320) | 560 (≥ 520) | 40 (≥ 30) | 70 | ≥ 32 | |
| | Solution annealed and quenched | | | | | | 40 (≥ 32) |

| Steels to be welded | |
|--|--|
| EN | ASTM |
| 1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2CrNi18-10, 1.4312 G-X10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10 | AISI 304, 304L, 304LN, 302, 321, 347; UNS S30400, S30403, S30453, S32100, S34700 ASTM A157 Gr. C9, A320 Gr. B8C or D |

| Approvals |
|-------------------------------|
| TÜV (10647), ,DNV GL, ABS, CE |

| Carton Packaging | |
|---|--|
|  | Weight: ~ 4.1 kg Diameter 2.0 x 300 mm 2.5 x 350 mm 3.2 x 350 mm 4.0 x 350 mm 5.0 x 450 mm |