OK 308L



Extra low carbon stainless steel electrode for welding steels of the 19Cr10Ni-type. Also suitable for welding stabilized stainless steels of the similar composition, except when the full creep resistance of the base material is to be met.

Specifications	
Classifications	SFA/AWS A5.4 : E308L-16 JIS Z 3221 : D308L-16

Welding Current	AC, DC+
Ferrite Content	FN 3-10
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile
Min AC OCV	50

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	420 MPa	570 MPa	45 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS		
As Welded	-60 °C	50 J

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**Ni**	**Cr**	**N**	**FN WRC-92**
0.03	0.7	0.9	10.0	19.3	0.10	5

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 300 mm	50-90 A	28 V	58 %	39 sec	1.0 kg/h
3.2 x 350 mm	70-130 A	31 V	60 %	54 sec	1.4 kg/h
4.0 x 350 mm	90-180 A	32 V	60 %	56 sec	2.0 kg/h