

AI-0208

Specifications

AS/NZS 1553.3 : E308L-16

AWS/ASME A5.4 E 308L-16 SME

Description and Applications

Rutile coated austenitic electrode for welding steels containing 16-21% Cr, 8-13% Ni (Generally type 304 S/S) when easy welding and fine bead appearance are required.

Typical Weldmetal Analysis

C	Mn	Cr	Fe	Ni	Si
0.02	0.9	19.3	Bal	9.7	0.8

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	600MPa
Yield Strength (0.2%)	450Mpa
Elongation	45% (4d)
Recovery	160%
Charpy V	40J (-105°C) 30J (20°C)

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	50-90
3.2	DC /AC	80-120
4.0	DC /AC	110-160

Also available as TIG: **AI-0208T** and MIG wire: **AI-1708LSi**, **AI-1708H**

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au

