

S-308L.16N[17]

Type : Rutile, Rutile-acid



Conformances

AWS A5.4/ ASME SFA5.4 E308L-16
 JIS Z3221 ES308L-16 / EN ISO 3581-A-E 199 L R
 AWS A5.4 / ASME SFA5.4 E308L-17
 JIS Z3221 ES308L-17 / EN ISO 3581-A-E 199 L R
 KR RD308L
 ABS AWS A5.4 E308L-16
 AWS A5.4 E308L-17
 LR 304L
 BV 308L

DNV-GL NV 308L
 NK KD308L
 CWB CSA W48 E308L-16
 TÜV EN ISO 3581-A - E 199 L
 DB DIN EN ISO 3581-A-E 199 L R
 CE
 CCS 304L

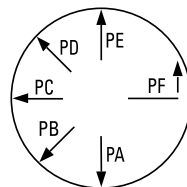
Applications

- Stainless steel (low carbon 18%Cr-8%Ni)

Features

- Good resistance to corrosion and oxidizing environments
- Easy to remove slag
- Good bead appearance
- High moisture resistance (17 type)

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard		Vacuum				P.V.C	
		packet 5kg(11lbs)	carton 20kg(44lbs)	packet 1.5kg(3.3lbs)	carton 15kg(3.3lbs)	packet 5kg(11lbs)	carton 20kg(44lbs)	packet 2.5kg(11lbs)	carton 10kg(22lbs)
2.0 (5/64)	300 (12)								✓
2.6 (3/32)	300 (12)								✓
3.2 (1/8)	350 (14)								✓
4.0 (5/32)	350 (14)								✓
5.0 (3/16)	350 (14)								✓

SMW

SAW

GMW

GTAW

FCW

Non-FERROUS

APPENDIX

Typical Chemical Composition of All-Weld Metal (%)

Product name	C	Si	Mn	P	S	Cr	Ni
S-308L.16N	0.02	0.67	0.87	0.028	0.018	19.2	10.0
S-308L.17	0.02	0.63	0.98	0.028	0.017	19.0	9.9

Typical Mechanical Properties of All-Weld Metal

Product name	TS MPa(lbs/in ²)	EL (%)
S-308L.16N	561 (81,500)	44.0
S-308L.17	570 (82,800)	49.0

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F & HF	25~55	50~85	70~115	95~145	135~180
V-up, OH	20~50	45~80	65~110	85~135	-



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