BOHLER FOX S 308L-16 (Avesta 308L-16 *)

böhler welding by voestalpine

SMAW electrode, High alloyed

Classification		
AWS A5.4	**EN ISO 3581-A**	**GB/T 983**
E308L-16	E 19 9 L R	E308L-16

Characteristics and typical fields of application

19Cr-9Ni stainless steel rutile electrode for all position welding of 1.4301/ASTM 304 type base metal. Good corosion resistance under fairly severe conditions, e.g. in oxidation acids and cold or dilute reducing acids

Base Materials

ASTM 304, 304L; BS304S31, 304S11, 304S61; SS2333, 2352

Typical analysis of all weld metal (Wt.-%)

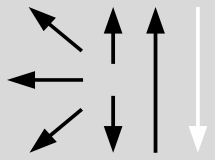
C	Si	Mn	Cr	Ni	Mo	Cu	N
0,02	0,7	0,60	19,8	9,5	0,05	0,03	0,07

Ferrite Number ≈ 3-10 FN WRC 92

Mechanical properties of the weld metal

Heat Treatment	Yield strength R_e N/mm^2	Tensile strength R_m N/mm^2	Elongation (L_0=4d_0)	Impact work ISO-V K_V (J)	
	MPa	MPa	%	+20°C	-40° C
As Welded	430 (≥ 320)	560 (≥ 520)	45 (≥ 30)	65(≥47)	55 (≥47)

Operating Data



Polarity
DC (+) / AC

Interpass temperature : 150°C
Heat Input: Max. 2.0 KJ/mm
Re-drying for 3 h at 250 – 280°C

Approval

ABS, CWB, CE

Size, Packing and Recommended welding parameters

Size (mm)	Kg / Pack	Kg / Box	Amperage (A)
2.50 x 300	3,63	10,89	50-80
3.25 x 350	4,10	12,30	60-120
4.00 x 350	4,10	12,30	110-160
5.00 x 450	4,54	13,62	150-200

* New product name. we confirm that above electrodes name are equal.