



## SECHERON 308L

**CODIFICATION :** AWS : SFA 5.4 E308L-16 (Nearest)

### CHARACTERISTICS AND APPLICATIONS :

Secheron 308L is stainless steel electrode for welding SS304, SS308 and its low carbon versions. The weld deposit displays good corrosion and crack resistance. It meets customer requirements economically. It works well with transformer having low OCV also with good re-striking characteristic. It has no red hot tendency within current range specified and no porosity. It is ideally suited for joining 18-8 stainless steels like AISI 304, 308 and its low carbon versions, etc. and their equivalent grades in cast variety.

It is specially recommended for welding lower diameter pipes with 1 mm to 3 mm wall thickness / 1 mm to 3 mm thick plates used in stainless steel furniture, stairs and general fabrication.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	P	S	Cr	Ni
Percent :	0.045	0.80	0.75	0.040	0.020	18.5	8.9

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	Elongation (L= 4d)%
560	38.0

### CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 150-180	110-140	80-110	60-80
Weight/Carton (kgs)	: 2.0	2.0	2.0	2.0

### PRECAUTIONS :

- 1 Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.
- 2 Use low current, short arc and stringer beads.