

Stainless Steel Electrodes

Alloy: WW308L-16 Class: E308L-16

Conforms to Certification: AWS A5.4 ASME SFA A5.4

Alloy: E308L-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

C = 0.04 max	Si = 1.00 max
Cr = 18.0 - 21.0	P = 0.04 max
Ni = 9.0 - 11.0	S = 0.03 max
Mo = 0.75 max	Cu = 0.75 max
Mn = 0.5 - 2.5	

Deposited All Weld Metal Properties %
(Typical) As-Welded

Yield Strength	84,500psi
Tensile Strength	55,000psi
Elongation	40%

Deposited Chemical Composition % (Typical)

C = 0.03	Si = 0.43
Cr = 19.40	P = 0.021
Ni = 9.3	S = 0.02
Mn = 1.65	

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Welding Parameters

<u>Diameter</u>	<u>Voltage</u>	<u>Amperage Flat Position</u>	<u>Amperage Vertical & Overhead</u>
3/32	24-28	70-85	65-75
1/8	26-30	85-110	80-90
5/32	28-32	110-140	100-120
3/16	28-32	120-160	110-130

Application

E308L-16 was developed for welding 304L. This electrode deposits a maximum of 0.4% carbon in the weld metal. It can be used successfully for welding type 321 and 347 steels.

