

Stainless Steel Electrodes

Alloy: WW308-16 Class: E308-16

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

Alloy: E308-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

| | |
|------------------|---------------|
| C = 0.08 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 = 19.4 | 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

E308-16 is designed for welding of the following 18-8 stainless steel types: 301, 302, 304 and 308. The weld deposit has the proper chemical content and balance for satisfactory welding of type 308, and therefore is suitable for welding 18-8 types of lower alloy content. Sound weld metal and corrosion resistance equal to or greater than that of the parent metal are assured.

