

spark 308-L

Electrode for joining austenitic,
Low Carbon, 18Cr-8Ni Stainless Steels

Classifications: AWSA5.4: E308L -16 || IS5206: E 19.9 LR26

Descriptions: Spark 308L is an all position welding electrode used for joining austenitic steels of the types 301, 302, 308, 308L, 304, 304L, 321 and 347. With lower than 0.04% carbon content, it provides high resistance to carbide precipitation and avoids the inter-granular corrosion.

Applications:

- Extensively used for welding of stainless steel pipelines in refineries, oil and gas industries.
- Storage tanks in chemical plants, power plants etc.
- Surface welding of impeller vanes, valves, heat exchangers.
- Nuclear plant structural welding and cryogenic steel equipment fabrication.

Welding Parameters:

| Size (mm X mm) | Current (Amps) |
|----------------|----------------|
| 2.50 x 350 | 55-80 |
| 3.15 x 350 | 70-100 |
| 4.00 x 350 | 90-130 |

Typical Mechanical Properties:

| | |
|----------------|-----------------------|
| UTS | 570 N/mm ² |
| Elongation | 42% |
| Yield Strength | 390 N/mm ² |

Typical All weld metal composition (%):

| C | Mn | Si | Cr | Ni | S | P |
|------|------|------|-------|------|-------|-------|
| 0.03 | 1.27 | 0.91 | 19.93 | 9.12 | 0.022 | 0.031 |