

spark 308

Electrode for fabrication of 18Cr-8Ni type austenitic stainless steels.

Classifications: AWSA5.4: E308 –16 || IS5206: E 19.9 R26

Descriptions: Electrode for welding 18-8 austenitic stainless steels corresponding to AISI 301, 302, 304, 305 and 308. Spark 308 electrode's intrinsic properties offers high corrosion resistance in acidic medium and provides smooth arc, low smoke & spatter and excellent slag detachability.

Applications:

- Welding of machinery in food, beverage industries, chemical & petrochemical industries.
- Finishing material in furniture making and welding of Ship hulls.
- Extensively used in general purpose fabrication utensils and machinery.

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	600 N/mm ²
Elongation	42%
Yield Strength	440 N/mm ²

Typical All weld metal composition (%):

C	Mn	Si	Cr	Ni	S	P
0.06	1.30	0.95	19.86	9.07	0.022	0.031