

AK E308-16

Description: E308-16 is a Cr18Ni9 stainless steel electrode with a rutile coating.AC and DC dual use, can perform all-position welding. The welding process performance is good, the arc is stable, the spatter is small, the slag removal is easy,and the welding seam is beautiful. The deposited metal has good resistance to intergranular corrosion.

Application: It is suitable for welding corrosion-resistant stainless steel structures whose working temperature is not lower than 300C, such as 06Cr19Ni9, 06Cr19Ni11Ti, etc.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.08	1.0	0.5- 2.5	0.03	0.04	9.0-11.0	0.75	18-21.0	0.75
Actual Result	0.06	0.78	0.96	0.01	0.028	9.35	0.09	19.86	0.08

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 550		≥ 30	
Actual Result	600		44	

Recommended welding parameters:

Diameter/ mm	2.0	2.5	3.2	4
Welding current/A	25-50	50-80	80- 110	110- 160