

AK E308L-16

Description: A super-low carbon stainless steel electrode designed to weld Cr19Ni10 type steels, the carbon content of its deposit metal is $\leq 0.04\%$. With excellent operation properties and pores resistance. Its weld metal with excellent mechanical and intergranular corrosion resistance performance.

Application: Used to weld Cr17 stainless steel structures where corrosion resistance and heat resistance is required.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.04	1.0	0.5- 2.5	0.03	0.04	9.0- 12.0	0.75	18- 21.0	0.75
Actual Result	0.021	0.62	0.72	0.005	0.020	9.75	0.13	19.22	0.25

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 510		≥ 30	
Actual Result	610		41	

Recommended welding parameters:

Diameter/mm		2.5	3.2	4.0
Welding current/A	F/H	60-80	80-120	100-150
	V/ OH	40-70	60-100	80-130