

Inweld 308L-16

AWS A5.4 E308L-16

Chemical Composition of Inweld 308L-16

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.04	18.0 -21.0	9.0-11.0	0.75	0.5-0.75	0.90	0.04	0.03	--	0.75

Single values are maximum unless otherwise specified.

Description and Applications

For All-Position welding austenitic low carbon 18% Chrome - 8% Nickel Stainless Steel such as 304L and steel castings of similar composition. Also used for stabilized stainless steels such as 321 and 347. The low carbon content of this electrode reduces the formation of chromium carbides, thereby protecting the corrosion resistant qualities of the weld deposit. Good strike and re-striking capability, smooth arc action with very little spatter and easy slag removal. Produces a finely rippled weld bead with a slightly concave shape that needs little or no post weld grinding or polishing. Used for fabrication and repair of stainless steel equipment in dairy distillery and restaurant equipment, chemical tanks and chemical engineering applications. Also used as a protective overlay on steel where medium hardness and complete corrosion resistance is required.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	75,000 psi
Yield Strength:	55,000 psi
Elongation:	35%

Recommended Parameters

SMAW

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
1/16"		25-35
3/32"		55-75
1/8"		75-110
5/32"		90-140
3/16"		85-120

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