

# Inweld 308L-17

AWS A5.4 E308L-17

## Chemical Composition of Inweld 308L-17

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.04	18.0 -21.0	9.0-11.0	0.75	0.5-2.5	0.90	0.04	0.03	---	0.75

Single values are maximum unless otherwise specified.

## Description and Applications

All-Position and very similar to 308L-16, but the -17 coating contains more silica and less titanium resulting in a “spray arc” effect when used on horizontal fillet welds. This also produces a weld deposit with a finer ripple appearance that is more flat to concave. Has a slower freezing slag giving it better handling characteristics when using a drag technique. For 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. 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:	60,000 psi
Elongation:	35%

## Recommended Parameters

SMAW

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32”		55-75
1/8”		75-110

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