



# EI 308L



Stainless Steel Flux Cored Welding Electrode - **AWS A5.4/ASME SFA-A5.4 2012: E308L-16**

### Key Benefits

- Excellent welding properties and weld bead appearance.
- Easy arc start.
- Low carbon content reducing risk for intergranular corrosion.
- Suitable for both AC and DC currents.

### Conformity and Approvals

AWS A5.4 2012:	E308L-16
ASME SFA-A5.4 2012:	E308L-16
CWB/CSA W-48-14:	E308L-16
EN ISO 3581-A:	E 19 9 L R 12

### Typical applications

- 301, 302 and 304-types stainless steels
- Austenitic stainless steels of 18% Cr and 8% Ni grade
- ASTM A743 and A744 Types CF-8 and CF-3

### Welding Positions



### Wire Composition as per AWS A5.4/A5.4M 2012: E308L-16

<b>Requirements – AWS E308L-16</b> Typical Wire Composition	<b>%C</b>	<b>%Mn</b>	<b>%Si</b>	<b>%S</b>	<b>%P</b>
	0.04 max. 0.019	0.5-2.5 0.98	1.00 max. 0.70	0.03 max. 0.013	0.04 max. 0.021
<b>Requirements - AWS E308L-16</b> Typical Wire Composition	<b>%Cr</b>	<b>%Ni</b>	<b>%Mo</b>	<b>%Cu</b>	<b>%V</b>
	18.0-21.0 19.69	9.0-11.0 10.38	0.75 max. 0.045	0.75 max. 0.03	- 0.036

### Mechanical Properties

	<b>Yield Strength MPa (ksi)</b>	<b>Tensile Strength MPa (ksi)</b>	<b>Elongation %</b>	<b>Ferrite Number (FN)</b>
<b>Requirements</b> As welded	Not specified	520 (75) min.	30 min.	Not specified
<b>Typical Results (all weld metal)</b> As Welded	455 (66)	615 (89)	38	6 - 10

## Ordering Information

Product Number	Product/AWS Specification	Dimension mm/inches	Single Pack Weight kg/lb	Box Weight kg/lb
1301708M32	EI-308L (E308L-16)	2.50 x 300 mm (3/32" x 12")	2.5 kg (5.5 lb)	7.5 kg (16.5 lb)
1301716M35	EI-308L (E308L-16)	3.25 x 350 mm (1/8" x 14")	5.0 kg (11.0 lb)	15.0 kg (33.0 lb)
1301720M35	EI-308L (E308L-16)	4.00 x 350 mm (5/32" x 14")	5.0 kg (11.0 lb)	15.0 kg (33.0 lb)
1301728M35	EI-308L (E308L-16)	5.00 x 350 mm (3/16" x 14")	5.0 kg (11.0 lb)	15.0 kg (33.0 lb)



Single Tube



Box