



E308L-16

DESCRIPTION: Weldcote Metals E308L-16 electrodes are used to weld unstabilized 18-8 stainless steels such as Types 301, 302, 304, 305, and 308. Weldcote Metals E308L-16 electrodes provide corrosion resistance and physical properties equal to or greater than the steels for which they are recommended. Typical applications include dairy, distillery and restaurant equipment, and chemical tanks.

APPROVALS: Manufactured under Quality System approved by ASME, IS09001. Meets AWS 5.4 Class E308L-16

CHEMICAL COMPOSITION

Carbon	0.04
Manganese	0.5-2.5
Silicon	0.90
Chromium	18.0-21.0
Nickel	9.0-11.0
Sulfur	0.03
Phosphorus	.04
Iron	Balance
Copper	0.75
Molybdenum	0.75

MECHANICAL PROPERTIES

Tensile Strength	
84,500 PSI	580 MPA
Yield Strength	
55,000 PSI	380 MPA
Elongation	
40%	

WELDING PARAMETERS

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.