

Classification

AWS A5.4	EN ISO 3581-A	GB/T 983
E308L-17	E 19 9 L R	E308L-17

Characteristics and typical fields of application

Avesta 308L-17 is a Cr-Ni rutile acid electrode for all position welding of ASTM 304 and 304L stainless steels. Weld metal features has a good resistance against intergranular corrosion (IGC ASTM A262 Practice E)

Base Materials

Outokumpu 4301, 4307, 4311, 4541; EN 1.4301, 1.4307, 1.4311, 1.4541; ASTM 304, 304L, 304LN, 321; BS 304S31, 304S11, 304S61, 321S31; NF Z7 CN 18-09, Z3 CN 18-10, Z3 CN 18-10 Az, Z6 CNT 18-10; SS 2333, 2352, 2371, 2337.

Typical analysis of all weld metal (Wt.-%)

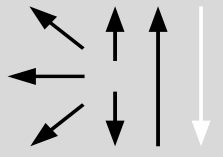
C	Si	Mn	Cr	Ni		
0.02	0.75	0.70	19.7	9.7		

Ferrite Number \approx 3-10 FN WRC 92

Mechanical properties of the weld metal

Heat Treatment	Yield strength	Tensile strength	Elongation	Impact work	
	R_e N/mm ²	R_m N/mm ²	($L_0=4d_0$)	ISO-V KV J	
	MPa	MPa	%	+20°C	-120°C
As Welded	420 (\geq 320)	580 (\geq 520)	40 (\geq 30)	60 (\geq 32)	33 (\geq 27)

Operating Data

	Polarity DC (+) / AC	Heat Input: Max. 2.0 kJ/mm
		Interpass temperature: Max. 150°C
		Scaling Temperature : Approx. 850°C
		Instruction for Re-drying: Re-dry for 3 h at 250-280°C before using

Approval

ABS, DNV-GL, CWB, CE

Size, Packing and Recommended welding parameters

Size (mm)	Kg / Pack	Kg / Box	Amperage (A)
2.50 x 350	5.00	15.00	50-80
3.25 x 350	5.00	15.00	80-120
4.00 x 450	5.00	15.00	100-160
5.00 x 450	5.00	15.00	160-220