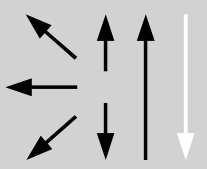


Classification					
AWS A5.4			EN 1600		
E308L-16			E 199 L R22		
Characteristics and typical fields of application					
Rutile electrode and is noted for its superior welding characteristic and metallurgy, Other characteristic include high current carrying capacity, minimum spatter formation, self releasing slag, smooth and clean weld profile, safety against formation of porosity due to moisture resistant coating and packaging into hermetically sealed tins. Resistant to intergranular corrosion (ASTM A262 Practice E).					
Base Materials					
ASTM 304, 304L; BS304S31, 304S11, 304S61; SS2333, 2352					
Typical analysis of solid wire (wt.-%)					
C	Si	Mn	Cr	Ni	Mo
0.02	0.7	0.7	19.5	10	0.03
Ferrite Range \approx 4 – 8 FN (WRC'92)					
Mechanical properties of all-weld metal					
Heattreat-ment	Yield strength R_e N/mm ²	Tensile strength R_m N/mm ²	Elongation ($L_0=5d_0$)	Impact work ISO-V KV J	
	MPa	MPa	%	+ 20 °C	-196 °C
As Welded	425	575	48	67	36
Operating data					
		Polarity DCEP/AC	Scaling Temperature : Approx. 850°C Interpass temperature : 150°C Heat Input: Max. 2.0 KJ/mm Rebaking for 3 h at 250 – 280°C Electrode Identification : Bohler Fox S 308L-16		
Approvals					
ABS					
Size, Packaging and Electrical Operating Data					
Size mm	Kg / Pack	Kg / Box	Amperage (A)		
2.50 × 300	3.63	10.89	50-75		
3.25 × 350	4.10	12.30	70-110		
4.00 × 350	4.10	12.30	100-150		