



## SUNWELD 308L

### CLASSIFICATION:

AWS A 5.4: E 308L-16  
IS: 5206:E19.9 LR 26  
DIN 8556:X2 Cr Ni 19.9

### DESCRIPTION:

SUNWELD 308L-16 is a stainless steel electrode depositing an extra low carbon 19 Cr-10 Ni weld metal which has excellent resistance to intergranular corrosion. The weld metal has higher resistance to cracking, oxidation and scaling at elevated temperatures. It possesses excellent weldability in all positions.

**APPROVALS:** PDIL, RDSO CLASS M2

### TYPICAL ALL WELD METAL PROPERTIES:

Chemical Composition (%)				Mechanical Properties	
C	0.03	Mn	0.80	UTS	55-66 Kg/mm <sup>2</sup>
Si	0.80	Cr	19	EL (L=4d)	45 %
Ni	10.00			Impact 20°C	56-80

### TYPICAL APPLICATIONS:

Ideally suited for welding austenitic stainless steels, wrought and cast materials of similar composition, welding of AISI 304, 304L, 308L & their equivalent for overlays and surfacing applications etc. Widely used in industries like food & beverage, chemicals etc.

### CURRENT RANGE & PACKING DATA:

Size	Length	Current Range	Qty of Electrodes in a	Qty. of Electrodes in a
(mm)	(mm)	(Amps)	Carton	Cardboard Box
2.5	350	60-80	2 Kg	10 Kg
3.15	350	80-100	2 Kg	10 Kg
4	350	100-140	2 Kg	10 Kg

### PACKING:

Electrodes are packed in Cartons and five of these Cartons are shrink wrapped in a cardboard box.