

LE P-308L

CLASSIFICATION

AWS A5.4 E308L-16
EN ISO 3581-A E 19 9 LR 12

GENERAL DESCRIPTION

LE P-308L is an extra low carbon rutile coated electrode. It gives a filler metal of the Cr-Ni type. Excellent quality smooth weld beads are highly resistant to acids, intergranular corrosion at operating temperatures up to 350°C, and to oxidation up to 800°C. It gives a stable arc and the slag is easy to remove.

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PE/4G



PF/3Gu

CURRENT TYPE

DC + ; AC min 50 V

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni
0.03	0.70	0.80	19	10

APPROVALS

ABS	BV	DNV/GL	CE	TÜV
E308L -16	308L	NV 308L	+	+

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)
					-20°C
Typical values	AW	420	570	45	80

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.0	2.5	3.2	4.0	5.0
	Length (mm)	250	250	300	350	350
Carton + PE foil	Pieces / unit	160	40	65	40	25
	Net weight/unit (kg)	1.6	1.6	2.1	2.2	2.1

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EXAMPLES OF MATERIALS TO BE WELDED

In addition to the welding of steels corresponding to AISI 301, 302, 304, 304L, 308 and 308L; LE P-308 L can also be used in the welding of niobium or titanium stabilized austenitic stainless steels. Welding of vapor and pressure fittings, storage tanks and equipment that are used in milk and other food industries, stainless steel or stainless steel plated steels operating under chemical attack are among its application areas. It is an ideal electrode for the joining of stainless steel parts (having similar chemical composition with the electrode) with steel cast pieces. Up to and including 3.25 mm diameter electrodes can be used in all positions; whereas 4 mm and 5 mm electrodes should be used in the flat position.

	EN 10088-1/-2	EN 10213-4	W. Nr.
Extra Low Carbon Stainless Steels (C < %0.03)	X2 CrNi 19 11	-	1.4306
	X2 CrNiN 18 10	-	1.4311
Medium Carbon Stainless Steels (C > %0.03)	X4 CrNi 18 10	-	1.4301
	X4 CrNi 18 12	-	1.4303
	-	G-X5 CrNi 19 10	1.4308
Stabilized Stainless Steels (Nb/Ti)	X6 CrNiTi 18 10	-	1.4541
	X6 CrNiNb 18 10	-	1.4550
	-	G-X5 CrNiNb 19 10	1.4552

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Electrode Weight [g/100 pcs]
2.0x250	45-60	DC+	990
2.5x250	60-80	DC+	1660
3.2x300	75-115	DC+	3230
4.0x350	115-150	DC+	5420
5.0x350	140-160	DC+	8112