OK 308L

SMAW

OK 308L has a heavy coating, produces a concave bead with a fine ripple and the slag is virtually self-cleaning. It is suitable for welding type 304, 304L, 308 and 308L with good bead appearance. The excellent wetting action and very fine ripple minimises crevice corrosion and grinding time. The low carbon content helps to prevent carbide precipitation.

Welding Current

DC+, AC OCV 50V

PACKING/ORDERING INFORMATION				
Part Number	Dia (mm)	Inner Carton (kg)	Carton Weight (kg)	Pallet Weight (kg)
6198252030	2.5	1.5	9.0	693.0
6198323020	3.2	4.1	12.3	811.8
6198403020	4.0	4.1	12.3	811.8
6198503020	5.0	3.9	11.7	772.2

CLASSIFICATIONS	TYPICAL ALL WELD METAL COMPOSITION (%)		TYPICAL MECH. PROPERTIES ALL WELD METAL
SFA/AWS A5.4	C	0.02	Yield Stress, Mpa
E308L-16	Si	0.8	420
JIS Z3221	Mn	0.7	Tensile Strength, Mpa
D308L-16	Cr	19.5	570
	Ni	10.0	Elongation, %
			45
			Charpy V
			Test Temps, °C Impact Values, J
			+20 70

WELDING PARAMETERS							
Diamater (mm)	Length (mm)	Welding Current, A	Arc Voltage, V	N. Kg Weld Metal/(kg) Electrodes	B. No. Of Elec-trodes/(kg) Weld Metal	H. Kg Weld Metal/(hour) Arc Time	T. Burn-off time, (secs)/ Electrode
2.5	300	60-90	31	0.55	99.0	1.1	36
3.2	350	80-120	31	0.60	49.0	1.4	54
4.0	350	120-170	32	0.60	33.0	2.0	60
5.0	350	150-240	33	0.60	20.0	3.0	60