Cromarod 308L

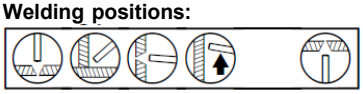
SMAW - (Stick) - MMA
Stainless Steel

Date: 2018-10-15
Revision: 25

Description:

Cromarod 308L is a rutile flux coated AC/DC electrode designed for the welding of low carbon 18%Cr / 10%Ni, type 304L, austenitic stainless steels. Operability is excellent with a low spatter arc producing a smooth weld bead surface and self-releasing slag. The electrode is all-positional up to and including 3.2 mm diameter. Cromarod 308L is also suitable for welding stainless steel grade 304 material, as well as Nb or Ti stabilised grades 347 and 321, when resistance to corrosion is primarily required. For structural applications at temperatures above 400 °C, Cromarod 308H is recommended because of its superior strength at elevated temperatures.

Welding positions:



Coating type:
Rutile

Welding current:
DC+, AC OCV > 39V

Ferrite content:
FN 7 (WRC-92)

Corrosion resistance
Good resistance to general and intergranular corrosion. Also good resistance to oxidising acids and cold reducing acids.

Scaling temperature:
Approx. 850 °C in air.

Redrying temperature:
350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			18,0	9,0
Typical	0,02	0,8	0,7	0,02	0,02	20,0	10,0
Max	0,030	0,90	2,0	0,025	0,025	21,0	11,0

	Mo	Cu	V	Nb
Min				
Typical	0,1			
Max	0,5	0,5	0,1	0,1

Mechanical properties

	Specified	Typical*
Yield strength, Rp0.2%:	≥ 320 MPa	450 MPa
Tensile Strength, Rm:	≥ 520 MPa	580 MPa
Elongation, A5	≥ 35%	39%
Impact energy, CV:	-20 °C • ≥ 50 J	-20 °C • 60 J
		-120 °C • 45 J

Classification:

AWS A5.4	E 308L-17
ISO 3581-A	E 19 9 L R 12

Approvals:

CE
DB — Kennblatt Nr. 30.042.04
TÜV
DNV GL
ABS
CWB

Note

Core wire:
P ≤ 0.020%
S ≤ 0.015%
N ≤ 0.080%

Product data:

Diam.mm	Length mm	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off electrode time (sec.)
2	300	35-60	28	0,62	143	0,7	31
2,5	300	40-80	28	0,62	91	1	33
3,2	350	80-120	29	0,64	45	1,5	45
4	350	100-160	30	0,64	31	2	55