



## SECHERON 308L

**CODIFICATION :** AWS : SFA 5.4 E308L-16 (Nearest)

### CHARACTERISTICS AND APPLICATIONS :

- Stainless steel electrode for welding SS304, SS308 and its low carbon versions.
- The weld deposit displays good corrosion and crack resistance.
- It meets customer requirements economically.
- It works well with transformer having low OCV also.
- It is ideally suited for joining 18-8 stainless steels like AISI 304, 308 and its low carbon versions, etc. and their equivalent grades in cast variety.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	S	P	Cr	Ni
Percent :	0.045	0.80	0.75	0.020	0.040	18.5	8.9

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	Elongation (L = 4d)%
560	38.0

### CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 150-180	110-140	80-110	60-80
Weight/Carton (kgs)	: 2.0	2.0	2.0	2.0

### PRECAUTIONS :

- 1 Re-dry the electrodes at 250-300°C for one hour for best results.
- 2 Use low current, short arc and stringer beads.