

S-308.16N

TYPE : Rutile

AWS A5.4 / ASME SFA5.4 E308-16
JIS Z3221 ES308-16
EN 1600 - E 19 9 R

Applications

Welding of 18%Cr-8%Ni steel.

Characteristics on Usage

S-308.16N is a lime-titania type electrode for 18%Cr-8%Ni steel with good usability. It is quite efficient because its burn-off rate and deposition rate are high because comparatively high amperage can be used.

Notes on Usage

- ① Keep the arc as short as possible.
- ② Remove dirt such as oil and dust from the groove.
- ③ Dry the electrodes at 350°C(662°F) for 60 minutes before use.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni
0.03	0.66	0.87	0.026	0.014	19.2	10.2

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
562 (81,600)	47.8

Approval

KR, ABS, DNV

I Packing

Packet 2.5 kg (5.5 lbs)
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F	25~55	50~85	70~115	95~145	135~180
V-up, OH	20~50	45~80	65~110	85~135	-