

S-308L.16N[17]

TYPE : Rutile, Rutile-acid

AWS A5.4 / ASME SFA5.4 E308L-16
JIS Z3221 ES308L-16 | EN 1600 - E 19 9 L R

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Applications

Welding of extra-low carbon 18%Cr-8%Ni steel.

Characteristics on Usage

S-308L.16N is a lime-titania type electrode for extra-low carbon 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.

S-308L.17 has a high moisture resistance and good porosity resistibility.

Notes on Usage

- ① It is mostly effective to proceed with welding, keeping the arc as short as possible in flat position.
- 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 (PA) 2F (PB) 3G (PF) 4G (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

Product Name	C	Si	Mn	P	S	Cr	Ni
S-308L.16N	0.02	0.67	0.87	0.030	0.018	19.2	10.0
S-308L.17	0.02	0.63	0.98	0.028	0.017	19.0	9.9

Typical Mechanical Properties of All-Weld Metal

Product Name	TS MPa(lbs/in ²)	EL (%)
S-308L.16N	561 (81,500)	44.0
S-308L.17	570 (82,800)	49.0

Approval

KR, ABS, LR, DNV, NK, BV, CWB,
TÜV, CE, DB, CCS (S-308L.16N)
ABS (S-308L.17)

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	-