

S-308LT.16

TYPE : Rutile

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

Applications

Welding of extra-low carbon 18%Cr-8%Ni stainless steel for cryogenic applications.

Characteristics on Usage

S-308LT.16 is a lime-titania type electrode for cryogenic applications, extra-low carbon 304L austenitic steel with good usability. It is provided with a good usability for all-position welding. It is quite efficient because its burn-off deposition rates are high because comparatively high amperage can be used.

Notes on Usage

- ① Dry the electrodes at 350°C(662°F) for 60 minutes before use.
- ② Keep the arc as short as possible, and avoid large width of weaving.
- ③ Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose for preventing blowholes at the arc starting.

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
0.035	0.77	1.74	0.023	0.012	19.2	9.9

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
576 (83,500)	49.8	-196 (-321)	36 (27)

Approval

ABS

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 - 150	135 - 180
V-up, OH	20 - 50	45 - 80	65 - 110	85 - 135	-