

S - 308L.17

SHIELDED METAL ARC WELDING CONSUMABLE
FOR WELDING OF 18% Cr-8% Ni STAINLESS STEEL



❖ Specification

AWS A5.4	E308L-17
JIS Z3221	ES308L-17
EN 1600	E 19 9 L R

❖ Applications

S-308L.17N is designed for welding of 18%Cr-8%Ni stainless steels. (Petrochemical processing, textile industries etc.)

❖ Characteristics on Usage

1. S-308L.17N is a Rutile-acid 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.
2. S-308L.17N has a high moisture resistance and good porosity resistance

❖ Note 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 electrode at 350°C(662°F) for 60 minutes before use.

❖ Type of Current

AC or DC+

❖ Packing

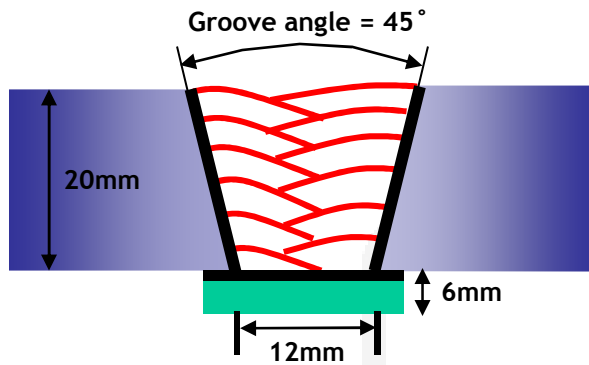
Packet	2.5kg(5.5lbs)
Carton	2.5kg(5.5lbs) X 4 : 10kg(22lbs)



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions

Method by AWS Spec.



Diameter(mm)	: 4.0mm
Amp./ Volt.	: 140/25
Travel speed(Cm/min)	: 13~18
Pre-Heat(°C)	: R.T .
Inter-pass Temp.(°C)	: 150±15
Position	: Flat
Polarity	: AC or DC+

[Joint Preparation & Layer Details]

❖ Mechanical Properties of All weld metal

Consumable	Tensile Test		CVN Impact Test (Joule)	
	TS(MPa)	EI(%)	-60℃	-196℃
S-308L.17	580	50.4	50	26
AWS A5.4 E308L-XX	≥ 520	≥ 35	Not Specified	

❖ Chemical Analysis of All weld metal(wt%)

Consumable	Chemical Composition (%)								
	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
S-308L.17	0.023	0.56	0.82	0.026	0.015	10.03	18.98	0.17	0.12
AWS A5.4 E308L-XX	≤0.04	≤1.0	0.5~2.5	≤0.04	≤0.03	9.0~11.0	18.0~21.0	≤ 0.75	≤ 0.75

This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.

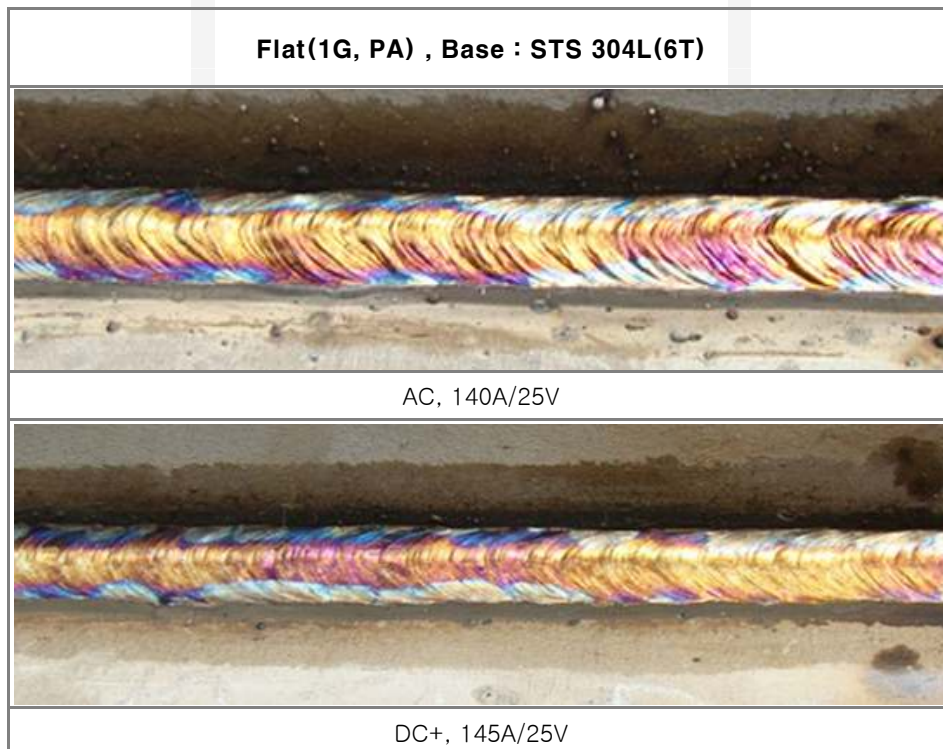


**Mechanical Properties
& Chemical Composition of All Weld Metal**

❖ **δ – Ferrite No.**

Consumable	Diagram		
	Schaeffler	Delong	WRC(1992)
S-308L.17	10.3	10.9	8.2

❖ **Bead Appearance**



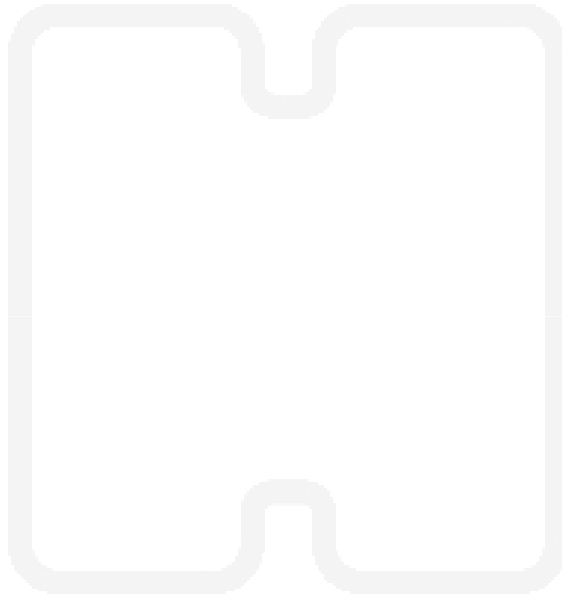
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Approvals

❖ AUTHORIZED APPROVAL DETAILS

Consumable	ABS		
S-308L.17	AWS A5.4 E308L-17 2.0~5.0		



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