

EI 308L

Coated Electrode for Stainless Steels -

Standards

AWS/ASME SFA - 5.4	E308L-16
EN ISO 3581 - A	E 19 9 L R 12
TS EN ISO 3581 - A	E 19 9 L R 12
EN 1600	E 19 9 L R 12

Properties and Applications

Rutile coated electrode for welding austenitic stainless Cr-Ni steels or cast steels, having an extra low carbon content, as well as stainless or heat resisting chromium steels or cast steels. Suitable for welding stainless steel tanks, valves, pipes and linings in chemical, food, beverage, pharmaceutical industries. For operating temperatures of up to +350°C, non-scaling up to +800°C. Possible to use equally well both with AC and DC. Easy arc striking and re-striking. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easily removable slag.

Approvals & Certificates

TSE HAKC	CE CWB	GOST TUV
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Materials

Width	Material	ASTM
X5CrNi18-10	1.4301	304
X4CrNi18-12	1.4303	305
X2CrNi19-11	1.4306	304L
GX5 Cr Ni 19 10	1.4308	CF-8
X2CrNiN 18-10	1.4311	304LN
X6CrNiTi18-10	1.4541	321
X6CrNiNb18-10	1.4550	347, 347H
GX5CrNiNb 19-11	1.4552	

Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr	Ni
Weld Deposit	0.02	0.7	0.9	19.50	10.00

Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	440	570	42	20°C → 70

Application Information

Welding Positions

PA PB PC PD PE PF

Polarity:

Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.00x250	35-55
2.00x300	35-55
2.50x250	50-80
2.50x300	50-80
2.50x350	50-75
3.25x300	80-120
3.25x350	80-120
4.00x350	100-165
5.00x350	140-220

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
13003CIEM1	2.00x250	125 AD	1.30	9	11.90	VAC Box
13003CIEM2	2.00x250	152 AD	1.54	9	14.10	VAC Box
13003DDEM2	2.00x300	225 AD	2.62	3	8.00	Plastic Box
13003DIEM1	2.00x300	125 AD	1.44	9	13.20	VAC Box

13003DJEM2	2.00x300	158 AD	1.79	9	16.30	VAC Box
13003FIEM1	2.50x250	80 AD	1.23	9	11.30	VAC Box
13003FIEM2	2.50x250	102 AD	1.54	9	14.10	VAC Box
13003GDEM2	2.50x300	135 AD	2.62	3	8.00	Plastic Box
13003GEEM2	2.50x300	216 AD	4.21	3	12.80	Plastic Box
13003GIEM1	2.50x300	80 AD	1.53	9	14.00	VAC Box
13003GJEM2	2.50x300	95 AD	1.79	9	16.30	VAC Box
13003HJEM1	2.50x350	80 AD	1.82	9	16.60	VAC Box
13003M9EM1	3.25x300	10 AD	0.34	30	10.40	Blister
13003MDEM2	3.25x300	83 AD	2.62	3	8.00	Plastic Box
13003MEEM2	3.25x300	133 AD	4.21	3	12.80	Plastic Box
13003MJEM1	3.25x300	60 AD	1.86	9	17.00	VAC Box
13003MJEM2	3.25x300	58 AD	1.79	9	16.30	VAC Box
13003NDEM2	3.25x350	71 AD	2.64	3	8.10	Plastic Box
13003NEEM2	3.25x350	141 AD	5.21	3	15.80	Plastic Box
13003NJEM1	3.25x350	60 AD	2.19	9	19.90	VAC Box
13003NJEM2	3.25x350	56 AD	2.04	9	18.60	VAC Box
13003QDEM2	4.00x350	45 AD	2.62	3	8.00	Plastic Box
13003QEEM1	4.00x350	90 AD	5.00	3	15.20	Plastic Box
13003QEEM2	4.00x350	91 AD	5.21	3	15.80	Plastic Box
13003QJEM1	4.00x350	40 AD	2.26	9	20.60	VAC Box
13003QJEM2	4.00x350	36 AD	2.04	9	18.60	VAC Box
13003T9EM1	5.00x350	7 AD	0.63	30	19.00	Blister
13003TEEM2	5.00x350	60 AD	5.21	3	15.80	Plastic Box
13003TJEM2	5.00x350	24 AD	2.04	9	18.60	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
 It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
 It has to be dried at 350°C for 2 hours.