Selectarc Inox 308B

Basic coated
Stainless Steel Electrode

Classification

AWS A5.4 : E308L-15 EN 1600 : E 19 9 L B 4 2
ISO 3581-A : E 19 9 L B 4 2

Description & Applications

Low carbon austenitic stainless steel electrode, basic type coating with ~ 8 % ferrite. Stable arc, good slag removal, regular weld beads. Good behaviour in positional welding and on bad prepared joints. Excellent mechanical properties. Used on 18/8 stainless steels for service temperatures from –196 °C up to +350 °C.

Main applications: For tubes, tanks, heat exchangers, piping systems.

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088	Material N°	UGINE
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B, D, E
S30403	304L	X2CrNi19-11	1.4306	UGINOX 18-10 L
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb18-10	1.4550	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Fe
<0.04	0.4	1.6	19.0	9.5	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>380	>560	>35	+20°C >90 -196°C >30

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	70	90	120

Redrying at 250°C during 1 hour, if necessary. Interpass temperature : < 150°C.

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