

# Linox 308L

SMAW

**CLASSIFICATION**

AWS A5.4	E308L-17	A-Nr	8	Mat-Nr	1.4316
ISO 3581-A	E 19 9 L R 3 2	F-Nr	5		
		9606 FM	5		

**TEMPERATURE RANGE**

Pressurized parts :-196...+350°C  
 Oxidation resistance :to 800°C

**GENERAL DESCRIPTION**

A rutile stainless steel electrode for 304L or equivalent steels  
 Smooth weld appearance  
 Minimum spatter and high resistance to porosity  
 Good side wall wetting, no undercut  
 Easy slag removal  
 Weldable on AC and DC  
 Also available in PROTECH™ Vacuum Pack

**WELDING POSITIONS (ISO/ASME)**


PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

**CURRENT TYPE**

AC / DC +

**APPROVALS**

<b>ABS</b>	<b>DNV</b>	<b>TÜV</b>
+	Pending	+

**CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL**

C	Mn	Si	Cr	Ni	FN [acc.WRC 1992]
0.025	0.8	0.8	19.0	9.5	3-10

**MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL**

Condition	0.2% Proof strength [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation [%]	Impact ISO-V(J)	
				+20°C	-20°C
Required: AWS A5.4 ISO 3581-A Typical values	not required min. 310 450	min. 520 min. 510 590	min. 35 min. 30 45	not required not required 70	50

**PACKAGING AND AVAILABLE SIZES**

	Diameter (mm) Length (mm)					
		2.0	2.5	3.2	4.0	5.0
<b>Carton + PE foil</b>	<b>Pieces / unit</b>	196	120	80	55	32
	<b>Net weight/unit (kg)</b>	2.3	2.53	2.78	3.69	3.43
<b>Protech™</b>	<b>Pieces / unit</b>	160	110	69	45	30
	<b>Net weight/unit (kg)</b>	1.84	2.32	2.4	3.09	3.2

Identification Imprint: 308L-17 / LINOX 308 L Tip Color: none

Linox308L: rev. C-EN03-01/02/16

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.  
 Fumes: Safety Data Sheets (SDS) are available on our website.

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## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
<b>Extra low carbon [C &lt;0.03%]</b>					
	X2CrNi19-11		1.4306	(TP)304L CF-3	S30403 J92500
<b>Medium carbon [C &gt;0.03%]</b>					
	X4CrNi18-10		1.4301	(TP)304	S30409
		GX5CrNi19-10	1.4308	CF 8	J92600
<b>Ti-, Nb stabilized</b>					
	X6CrNiTi18-10		1.4541	(TP)321 (TP)321H	S32100 S32109
	X6CrNiNb18-10		1.4550	(TP)347 (TP)347H	S34700 S34709
		GX5CrNiNb19-10	1.4552	CF-8C	J92710

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## WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions				
	PA/1G	PB/2F	PC/2G	PF/3Gup	PE/4G
2.0		45A	45A	40A	40A
2.5	70A	70A	70A	60A	60A
3.2	100A	100A	100A	70A	70A
4.0	140A	140A	140A		
5.0	180A	180A			