

KS-308L-17

Classification

AWS A5.4/A5.4M	E308L-17
JIS Z3221	ES308L-17
EN ISO 3581-A	-
GB T983	E308L-17

Coating Type : Lime Titania

Applications and Features

- (1) Weld metal is austenitic structure with 19%Cr-9%Ni.
- (2) Low carbon content can improve intergranular corrosion resistance.
- (3) Suitable for welding AISI 301, 302, 304S, SUS 304 or 304L.
- (4) Ideal for welding petrochemical industry, pressure vessel and food machine.

Welding Position



Welding Instruction

- (1) Please refer to Appendix A.
- (2) Please refer to Appendix F.

Typical Weld Metal Composition (wt%)

C	Si	Mn	P	S	Cr	Ni
0.02	0.71	0.72	0.028	0.008	20.33	9.75

Typical Weld Metal Mechanical Properties

Tensile strength	Yield strength	Elongation
N/mm ²	N/mm ²	%
576	412	43

Available Sizes and Welding Parameters (AC or DC+)

Diameter (mm)		2.6	3.2	4.0	5.0
Current (A)	F/HF	50~85	80~120	100~150	140~180
	V-up/OH	45~80	70~110	90~135	-