

Classifications

EN ISO 3581-A	AWS A5.4 / SFA-5.4
E 19 9 L R 3 2	E308L-17

Characteristics and typical fields of application

Rutile coated, core wire alloyed electrode for welding of stainless austenitic steels such as 1.4301 and 1.4307 / 308L. Easy to weld on both AC and DC+ with minimum spatter formation. The slag is self-releasing and the resulting weld is smooth and clean. Max. service temperature 350°C.

Base materials

1.4301 X5CrNi18-10, 1.4306 X2CrNi19-11, 1.4307 X2CrNi18-9, 1.4311 X2CrNi18-9, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10
UNS S30400, S30403, S30453, S32100, S34700
AISI 304, 304L, 304LN, 302, 321, 347

Typical analysis

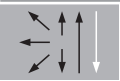
	C	Si	Mn	Cr	Ni
wt.-%	0.03	0.8	0.8	19.8	10.2

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	-120°C
u	430 (≥ 320)	560 (≥ 520)	40 (≥ 30)	70	38 (≥ 32)

u untreated, as welded

Operating data

	Polarity	DC+ / AC	Dimension mm	Current A
	Electrode identification	Q E 308L-17 / 308L-17 / E 19	2.5 × 300	50 – 90
		9 L R	3.2 × 350	80 – 120
			4.0 × 350	110 – 160

Suggested heat input is max. 2.0 kJ/mm and interpass temperature max. 150°C.

Approvals

TÜV (10647), ABS, DNV, CE