

SUPRANOX RS 308L

MMA Electrodes Stainless and Heat resistant steels

Semi-basic MMA electrode suitable for the welding of austenitic steels containing 16-20% Cr and 8-12% Ni (i.e. AISI 304, AISI 304L). The weld deposit has a 0,04% max Carbon content. Particularly suitable for nuclear, chemical and associated applications. Excellent weldability with a spatter free arc, self-releasing slag producing a very smooth bead appearance. Max service temperature +300°C. Efficiency 100%. Packed in Gaspack system.

Classification	
AWS	A5.4: E 308L-16
EN	1600: E 19 9L R 12
GOST	10052-75: Э04Х20Н9

Approvals	Grades
ABS	
MMI	
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.021	0.90	0.80	≤ 0.025	≤ 0.025	19	9.50	-	-	-	-	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 320	≥ 520	≥ 35	≥ 80	-

Materials

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4311 (X2CrNiN18-10)

AISI 304 - 304L - 302

Storage and redrying

Keep dry and avoid condensation.

Re-drying not generally required

If necessary: 350-370 °C for 1 hour, 3 times max

Current condition and welding position

AC; DC+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
1,6	250	20-30	5,8	3,2
2,0	300	30-60	11,2	6,7
2,5	300	50-80	18,7	11,2
3,2	350	60-120	35,0	21,0
4,0	350	100-140	52,8	31,6
5,0	350	130-180	81,6	48,9