# OK 308L




Extra low carbon stainless steel electrode for welding steels of the 19Cr10Ni-type. Also suitable for welding stabilized stainless steels of the similar composition, except when the full creep resistance of the base material is to be met.

| Specifications | |
|---|---|
| **Classifications** | SFA/AWS A5.4 : E308L-16<br>JIS Z 3221 : D308L-16 |

| | |
|---|---|
| **Welding Current** | AC, DC+ |
| **Ferrite Content** | FN 3-10 |
| **Alloy Type** | Austenitic CrNi |
| **Coating Type** | Acid Rutile |
| **Min AC OCV** | 50 |

| Typical Tensile Properties | | | |
|---|---|---|---|
| **Condition** | **Yield Strength** | **Tensile Strength** | **Elongation** |
| **AWS** | | | |
| As Welded | 420 MPa | 570 MPa | 45 % |

| Typical Charpy V-Notch Properties | | |
|---|---|---|
| **Condition** | **Testing Temperature** | **Impact Value** |
| **AWS** | | |
| As Welded | -60 °C | 50 J |

| Typical Weld Metal Analysis % | | | | | | |
|---|---|---|---|---|---|---|
| **C** | **Mn** | **Si** | **Ni** | **Cr** | **N** | **FN WRC-92** |
| 0.03 | 0.7 | 0.9 | 10.0 | 19.3 | 0.10 | 5 |

| Deposition Data | | | | | |
|---|---|---|---|---|---|
| **Diameter** | **Current** | **Voltage** | **Efficiency (%)** | **Fusion time per electrode at 90% I max** | **Deposition Rate** |
| 2.5 x 300 mm | 50-90 A | 28 V | 58 % | 39 sec | 1.0 kg/h |
| 3.2 x 350 mm | 70-130 A | 31 V | 60 % | 54 sec | 1.4 kg/h |
| 4.0 x 350 mm | 90-180 A | 32 V | 60 % | 56 sec | 2.0 kg/h |