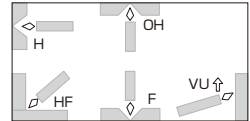


Covered electrode for low carbon 18%Cr-8%Ni steel**Classification:** ASME / AWS A5.4 E308L-16**Features:** - Applicable for 304L type steel
- Lower carbon content than **NC-38****Redrying Conditions:** 150~200°Cx0.5~1h**Identification color:** 1st Red, 2nd -**Welding Positions:****Chemical composition of all-weld metal (%) as per AWS**

	C	Si	Mn	P	S	Ni	Cr
Example	0.034	0.33	1.43	0.022	0.006	9.57	20.07
Guaranty	≤0.04	≤0.90	0.5~2.5	≤0.04	≤0.03	9.0~11.0	18.0~21.0

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	410	580	48	0°C: 78
Guaranty	-	≥520	≥35	-

Recommended welding parameters

	2.0mm	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	25~55A	50~85A	70~115A	95~145A	135~180A
VU, OH	20~50A	45~80A	65~110A	85~135A	-

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

LR	BV	NK	GL
304Lm(Chem.)	UP(E308L-16)	KD308L	4306

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.0	250	2	20	9
2.6	300	2	20	18
3.2	350	5	20	33
4.0	350	5	20	51
5.0	350	5	20	79