



OK 308L

SMAW

OK 308L has a heavy coating, produces a concave bead with a fine ripple and the slag is virtually self-cleaning. It is suitable for welding type 304, 304L, 308 and 308L with good bead appearance. The excellent wetting action and very fine ripple minimises crevice corrosion and grinding time. The low carbon content helps to prevent carbide precipitation.

Welding Current

DC+, AC OCV 50V



| PACKING/ORDERING INFORMATION | | | | |
|------------------------------|----------|-------------------|--------------------|--------------------|
| Part Number | Dia (mm) | Inner Carton (kg) | Carton Weight (kg) | Pallet Weight (kg) |
| 6198252030 | 2.5 | 1.5 | 9.0 | 693.0 |
| 6198323020 | 3.2 | 4.1 | 12.3 | 811.8 |
| 6198403020 | 4.0 | 4.1 | 12.3 | 811.8 |
| 6198503020 | 5.0 | 3.9 | 11.7 | 772.2 |

| CLASSIFICATIONS | TYPICAL ALL WELD METAL COMPOSITION (%) | TYPICAL MECH. PROPERTIES ALL WELD METAL |
|---------------------|--|---|
| <u>SFA/AWS A5.4</u> | C 0.02 | <u>Yield Stress, Mpa</u> |
| E308L-16 | Si 0.8 | 420 |
| <u>JIS Z3221</u> | Mn 0.7 | <u>Tensile Strength, Mpa</u> |
| D308L-16 | Cr 19.5 | 570 |
| | Ni 10.0 | <u>Elongation, %</u> |
| | | 45 |
| | | <u>Charpy V</u> |
| | | Test Temps, °C Impact Values, J |
| | | +20 70 |

| WELDING PARAMETERS | | | | | | | |
|--------------------|-------------|--------------------|----------------|----------------------------------|--------------------------------------|----------------------------------|-------------------------------------|
| Diameter (mm) | Length (mm) | Welding Current, A | Arc Voltage, V | N. Kg Weld Metal/(kg) Electrodes | B. No. Of Electrodes/(kg) Weld Metal | H. Kg Weld Metal/(hour) Arc Time | T. Burn-off time, (secs)/ Electrode |
| 2.5 | 300 | 60-90 | 31 | 0.55 | 99.0 | 1.1 | 36 |
| 3.2 | 350 | 80-120 | 31 | 0.60 | 49.0 | 1.4 | 54 |
| 4.0 | 350 | 120-170 | 32 | 0.60 | 33.0 | 2.0 | 60 |
| 5.0 | 350 | 150-240 | 33 | 0.60 | 20.0 | 3.0 | 60 |

