

MODI SS-308L

Classification:
AWS A/ 5.4 : E308L-16

Description:

MODI SS- 308L is low carbon rutile coated austenitic stainless steel electrode with improved weldability having upto 10 FN (Ferrite Content) which provide resistance to cracking, easy striking and restriking without spatters, resistance to inter granular corrosion, very easy slag removal, smooth weld bead appearance etc.

Applications:

- ❖ Joining of AISI 301L, 302L, 304L & 308L Grades.
- ❖ Normal carbon grades like 302, 304 & 308.
- ❖ SS piping in refineries oil and gas Industries, chemical plants.
- ❖ Fabrication of furniture fittings, bathroom fittings, building structures, tube/pipes, tanks, heat exchangers etc

Chemical Composition of Weld Metal (WT. %):

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.04 Max	0.50 - 2.50	1.00 Max	0.030 Max	0.040 Max	9.0 - 11.0	18.0 - 21.0	0.75 Max	0.75 Max

Mechanical Properties of Weld Metal:

Tensile Strength (N/mm ²)	Elongation L=4d (%)
520 Min	35 Min

Current Conditions: AC (70 V) / DC (+)

Size (mm)	2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
Current (Amps)	50 - 80	80 - 110	110 - 150	150 - 180

Welding Positions: F, H, V-up, OH

Recommendation:

Re-dry the electrodes at 250°C for 1 hour. Keep the re-dried electrodes in holding oven before use (70 to 100°C). Use electrodes within recommended current conditions for better performance.

Caution:

Protect yourself and others. Fumes & gases can be dangerous to health. Arc rays can injure eyes and burn skin. Electric shock can kill. Refer American National Standard Z49.1 "Safety in welding and cutting".

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