

Stainless steel electrode

Classification

AWS A5.4 : E308L-16
EN 1600 : E 19 9 L R 12

Temperature Range

pressure parts: -196...+350°C
oxidation resistance: to 800°C

General description

Rutile basic all position stainless steel electrode for 304L or equivalent steels
Excellent corrosion resistance in oxidizing environments such as nitric acid
High resistance to intergranular corrosion
Smooth bead appearance
Easy slag release
Strong electrode coating
Weldable on AC and DC
Also available in vacuum sealed Sahara ReadyPack® (SRP)

Welding positions



ISO/ASME PA/1G PB/2F PC/2G PF/3G up PE/4G PF/5G up

Current type

AC / DC electr. + / -

Approvals

BV	TÜV
304L	+

Chemical composition (w%), typical, all weld metal

C	Mn	Si	Cr	Ni	FN
0.02	0.80	0.80	19.5	9.7	4-10

Mechanical properties, all weld metal

Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)		
				+20°C	-20°C	-196°C
Required: AWS A5.4 EN 1600	not required min. 320	min. 520 min. 510	min. 35 min. 30	not required not required		
Typical values	AW 440	580	43	70	60	35

Packaging, available sizes and identification

	Diameter (mm)	1.5	2.0	2.5	3.2	4.0	5.0
	Length (mm)	250	300	350	350	350	350
Unit: Box	Pieces / unit (nominal)	125	225	135	150	100	65
	Net weight/unit (kg)	0.7	2.3	2.6	4.8	4.9	4.8
Unit: SRP	Pieces / unit			69	56	29	
	Net weight/unit (kg)			1.4	1.9	1.5	

Identification

Imprint: 308L-16 / AROSTA 304 L

Tip colour: light blue

Arosta® 304L: rev. EN 20

Materials to be welded

Steel grades	EN 10088-1/-2	EN 10213-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Extra low carbon C <0.03%	X2 CrNi 19 11		1.4306	(TP)304L CF-3	S30403 J92500
X2 CrNiN 18 10			1.4311	(TP)304LN	S30453
Medium carbon C >0.03%	X4 CrNi 18 10		1.4301	302,304 (TP)304	S30400 S30409
		GX5 CrNi 19 10	1.4308	CF 8	J92600
Ti-, Nb stabilized	X6 CrNiTi 18 10		1.4541	(TP)321 (TP)321H	S32100 S32109
	X6 CrNiNb 18 10		1.4550	(TP)347 (TP)347H	S34700 S34709
		GX5 CrNiNb 19 10	1.4552	CF-8C	J92710

Calculation data

Sizes Diam. x length (mm)	Current range type (A)	Current	Arc time - per electrode at max. current - (s)*	Energy E(kJ)	Dep.rate H(kg/h)	Weight/ 1000 pcs. (kg)	Electrodes/ kg weldmetal B	kg Electrodes/ kg weldmetal 1/N
1.5 x 250	20 - 40	DC+	25	19	0.44	5.5	330	1.82
2.0 x 300	30 - 50	DC+	43	45	0.55	10.4	154	1.59
2.5 x 350	40 - 75	DC+	51	88	0.86	19.2	82	1.59
3.2 x 350	60 - 110	DC+	57	158	1.3	32.2	49	1.59
4.0 x 350	80 - 150	DC+	65	245	1.7	47.3	32	1.52
5.0 x 350	140 - 220	DC+	66	390	2.7	76.7	20	1.56

* stub end 35mm

Welding parameters, optimum fill passes

Welding positions Diameter (mm)	PA/1G Current (A)	PB/2F	PC/2G	PF/3G up	PE/4G	PF/5G up
1.5		35	35			
2.0		45	45	40	40	40
2.5	70	70	70	60	60	60
3.2	100	100	100	70	70	70
4.0	140	140	140	80		
5.0	180	180	180			

For root passes DC- is recommended.