

# EI 308L

*Coated Electrode for Stainless Steels -*

Standards	
AWS/ASME SFA - 5.4	E308L-16
EN ISO 3581 - A	E 19 9 L R 12
TS EN ISO 3581 - A	E 19 9 L R 12
DIN M. No.	1.4316

Approvals & Certificates		
CE CWB	HAKC TSE	TUV

Materials		
EN	Material	ASTM
X5CrNi18-10	1.4301	304
X4CrNi18-12	1.4303	305
X2CrNi19-11	1.4306	304L
GX5 Cr Ni 19 10	1.4308	CF-8
X2CrNiN 18-10	1.4311	304LN
X6CrNiTi18-10	1.4541	321
X6CrNiNb18-10	1.4550	347, 347H
GX5CrNiNb 19-11	1.4552	

## Properties and Applications

Rutile coated electrode for welding austenitic stainless Cr-Ni steels or cast steels, having an extra low carbon content, as well as stainless or heat resisting chromium steels or cast steels. Suitable for welding stainless steel tanks, valves, pipes and linings in chemical, food, beverage, pharmaceutical industries. For operating temperatures of up to 350°C, non-scaling up to 800°C. Possible to use equally well both with AC and DC. Easy arc striking and re-striking. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easily removable slag.



## Typical Chemical Values of Weld Metal

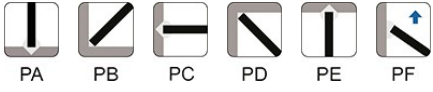
Type of Analysis	C	Si	Mn	Cr	Ni
Weld Deposit	0.02	0.70	0.90	19.50	10.00

## Typical Mechanical Values of Weld Metal

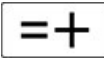

Test Condition	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	440	570	42	20°C → 70

### Application Information

**Welding Positions**



PA PB PC PD PE PF

**Polarity:**  

**Welding Parameters & Efficiency**

Diameter x Length (mm)	Current (A)	Weld Deposit(Kg)/1Kg Consumed Electrode	Number of Electrodes/1Kg Weld Deposit	Weld Metal Deposition Rate (Kg/h)	Efficiency(%)
3.25x350	80-120	0,57	50	1,54	102
2.50x250	50-80	0,54	127	0,94	102
2.50x300	50-80	0,55	101	0,98	103
4.00x350	100-165	0,56	33	2,05	103
3.25x300	80-120	0,56	60	1,47	103
2.00x300	35-55	0,57	158	0,64	103
2.50x350	50-75	0,55	89	0,98	103
5.00x350	140-220	0,57	21	2,67	103
2.00x250	35-55	0,57	174	0,64	104

### Packaging Information

Product Code	Diameter X Length (mm)	Pieces per Box (-)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
13003CIEM2	2.00x250	152 kg	1.5	10	14.1	VAC Box
13003DDEM2	2.00x300	225 kg	2.5	3	8.0	Plastic Box
13003DJEM2	2.00x300	158 kg	1.8	10	18.1	VAC Box
13003FIEM2	2.50x250	102 kg	1.5	10	14.1	VAC Box
13003GBEM2	2.50x300	51 kg	1.0	10	11.3	Plastic Box
13003GDEM2	2.50x300	135 kg	2.5	3	8.0	Plastic Box
13003GEEM2	2.50x300	216 kg	4.0	3	12.8	Plastic Box
13003GJEM2	2.50x300	95 kg	1.8	10	18.2	VAC Box
13003MDEM2	3.25x300	83 kg	2.5	3	8.0	Plastic Box
13003MJEM2	3.25x300	58 kg	1.8	10	18.2	VAC Box
13003NBEM2	3.25x350	29 kg	1.0	10	11.3	Plastic Box
13003NDEM2	3.25x350	71 kg	2.5	3	8.1	Plastic Box
13003NEEM2	3.25x350	141 kg	5.0	3	15.8	Plastic Box
13003NJEM2	3.25x350	56 kg	2.0	10	20.7	VAC Box
13003QBEM2	4.00x350	19 kg	1.0	10	11.3	Plastic Box
13003QDEM2	4.00x350	45 kg	2.5	3	8.0	Plastic Box
13003QEEM2	4.00x350	91 kg	5.0	3	15.8	Plastic Box
13003QJEM2	4.00x350	36 kg	2.0	10	20.7	VAC Box
13003TEFM2	5.00x350	60 kg	5.0	3	15.8	Plastic Box
13003TJEM2	5.00x350	24 kg	2.0	10	0.0	VAC Box

### Storage & Re-Drying Information

It can be dried maximum 5 times.  
It has to be dried at 350°C for 2 hours.