



E308-16

DESCRIPTION: Weldcote Metals E308-16 electrodes are used to weld unstabilized 18-8 stainless steels such as Types 301, 302, 304, 305, and 308. Weldcote Metals E308-16 electrodes provide corrosion resistance and physical properties equal to or greater than the steels for which they are recommended. Typical applications include dairy, distillery and restaurant equipment, and chemical tanks.

APPROVALS: Manufactured under Quality System approved by ASME, IS09001. Meets AWS 5.4 Class E308-16.

CHEMICAL COMPOSITION

| | |
|------------|---------|
| Carbon | .05 |
| Manganese | 1.65 |
| Silicon | .52 |
| Chromium | 23.5 |
| Nickel | 12.3 |
| Sulfur | .02 |
| Phosphorus | .021 |
| Nitrogen | .05 |
| Iron | Balance |

MECHANICAL PROPERTIES

Tensile Strength

84,500 PSI 580 MPA

Yield Strength

55,000 PSI 380 MPA

Elongation

40%

WELDING PARAMETERS

Direct Current
Electrode + Ve

AMPERAGES:

| | |
|-------|---------|
| 3/32" | 65-75 |
| 1/8" | 90-105 |
| 5/32" | 120-135 |
| 3/16" | 135-155 |

(For vertical welding amperages are to be reduced by 10 to 15 amps)

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.