

STARINOX 308L

MMA Electrodes

Stainless and Heat resistant steels

SAF-FRO

STARINOX 308L is a semi-basic MMA electrode suitable for the welding of austenitic steels Cr-Ni steels or cast steels containing 16-20%Cr and 8-12%Ni, i.e. AISI 304, AISI 304L. This electrode can also be used for welding of stainless steels of the same type whether stabilised or not for services temperatures UP to +350°C. The weld deposit has a carbon content <0,04%.

It is particularly suitable for food, nuclear, chemical industry and associated applications.

This electrode offers excellent operability and is particularly suitable for downhand butt and fillet welding applications, the 2.5mm and 3.2mm diameter electrodes can be used for positional welding.

Combines a stable spray arc transfer resulting in excellent weld bead shape and appearance with a slight concave profile in horizontal vertical fillet welds. There is very little spatter and in combination with the self-releasing slag, post welding cleaning time is maintained to a minimum. Under wet corrosive conditions suitable for operating temperatures up to 350°C, resistant to scaling up to 800°C. Suitable for use with either AC [minimum OCV 50V] or DC positive. Easy arc striking and restriking. Efficiency 100%.

Semi-basic electrode for welding type 304-308L austenitic stainless steels. Low carbon content.

Classification	
EN ISO	3581-A: E 19 9 L R 12
AWS	A5.4: E 308L-16

Approvals					
ABS	BV	DB	DNV	GL	TÜV
E308L-16	UP	●	308L	4550	●

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	P	S	Cr	Ni	Ferrite
All weld metal	0.025	0.9	0.8	≤ 0.030	≤ 0.025	19.8	9.5	5-10

All-weld metal Mechanical Properties


Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 320	≥ 520	≥ 35	≥ 60

Materials

1.4301 (X4CrNi18-10); 1.4303 (X4CrNi 18-12); 1.4306 (X2CrNi19-11); 1.4308 (GX5CrNi19-11); 1.4311 (X2CrNi18-10); 1.4319 (X5CrNi17-8); 1.4541 (X6CrNiTi18-10); 1.4550 (X6CrNiNb18-10); 1.4552 (GX5CrNiNb19-10)

AISI 304-304L-303-302-301; ASTM A312 Grades TP308, TP308L; ASTM A351 Grades CF3, CF3A

Storage
Keep dry and avoid condensation.
Re-drying not generally required.
If necessary 250°-300°C for 1 hour, 5 times max.

Current condition and welding position
AC; DC+


Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	GASP		VPMD	
				PC	Code	PC	Code
2.0	300	30-60	11.2	310	W000375894	150	W000288719
2.5	300	55-80	18.7	190	W000375897	90	W000288720
3.2	350	70-110	35.0	120	W000375899	55	W000288722
4.0	350	120-140	52.8	80	W000375901	40	W000288723
5.0	350	145-180	81.6	50	W000375905	20	W000288724