

Exaton 308/308L-17

308/308L-17 is a chromium-nickel covered electrode with acid rutile coating for welding of low carbon 18% Cr/10% Ni austenitic stainless steels. In cases where creep strength is of secondary importance 308/308L-17 is suitable for welding stabilized austenitic steels, e.g. ASTM 321 and 347. When a weld metal similar to the parent metal is not required 308/308L-17 can be used for welding ferritic and martensitic steels. The electrode has excellent arc stability, low spatter and fast burn off rate with minimal stub loss. It is also characterized by improved moisture resistance, self peeling slag, easy post weld finishing. 308/308L-17 gives smooth uniform beads and works in any standard weld position. The product is supplied in VacPac.

Specifications

Classifications	EN ISO 3581-A : E 19 9 L R 1 2 SFA/AWS A5.4 : E308L-17 Werkstoffnummer : 1.4316
Approvals	CE : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+, AC
Ferrite Content	FN 3-10
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	440 MPa (64 ksi)	600 MPa (87 ksi)	40 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C (68 °F)	75 J (56 ft-lb)
As Welded	-20 °C (-4 °F)	60 J (44 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.025	0.75	0.9	0.014	0.024	9.5	19	0.04	0.04	0.062

Typical Weld Metal Analysis %

FN WRC-92
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Deposition Data

Diameter	Current	Voltage	Deposition Efficiency (%)	Burn-off Time /Electrode	Deposition Rate @ 90% I max
2.5 x 300.0 mm (0.098 x 11.8 in.)	50-90 A	28 V	58 %	39 sec	1.0 kg/h (2.2 lbs/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	70-130 A	31 V	60 %	54 sec	1.4 kg/h (3.1 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	90-180 A	32 V	60 %	56 sec	2.0 kg/h (4.4 lbs/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	140-250 A	33 V	60 %	60 sec	2.8 kg/h (6.2 lbs/h)