

Arcaloy 308L-17 Plus

Arcaloy 308L-17 Plus electrodes have a heavy coating, produce a concave bead with minimum ripple and the slag is virtually self-cleaning. These electrodes are designed to weld Types 304, 304L, 321 and 347 for corrosion service at temperature up to about 600°F(315°C). The excellent wetting action and very fine ripple minimize crevice corrosion and grinding time. This is particularly useful in the food and drink industry where a smooth polished surface is required.

Specifications	
Classifications	ASME II SFA A5.4 : E308-17/E308L-17 ASME IX : F No. 5 AWS A5.4 : E308-17/E308L-17
Approvals	CWB : CSA W48 E308L-17
Industry	Food and Beverage Railcars Industrial and General Fabrication Ship/Barge Building

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

Alloy Type	308L-17 Plus
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Typical Tensile Properties		
Yield Strength	Tensile Strength	Elongation
400 MPa (58 ksi)	550-600 MPa (86 ksi)	(in 2") 47 %

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	Cu	Ferrite FN
0.02	0.6	0.8	10	19	0.1	0.1	6

Recommended Welding Parameters			
Wire Diameter	Flat Amps	Vertical Amps	Overhead Amps
1.6 mm (1/16 in.)	20-35 A	15-25 A	20-30 A
2.0 mm (5/64 in.)	30-50 A	25-35 A	30-40 A
2.4 mm (3/32 in.)	60-85 A	40-60 A	40-60 A
3.2 mm (1/8 in.)	90-120 A	70-80 A	60-85 A
4.0 mm (5/32 in.)	140-165 A	80-90 A	95-120 A
4.8 mm (3/16 in.)	180-210 A	100-115 A	125-150 A
6.4 mm (1/4 in.)	205-290 A		