

Arcaloy 308L-15

Arcaloy 308L-15 electrodes were developed for the welding of Type 304L stainless steels but can be used for many other stainless steels including Types 301, 302 & 304. They are used extensively for the welding of chemical plant equipment and may be used successfully for the welding of Types 321 and 347 stainless steels provided the service temperature is less than about 700°F (375°C). The basic coating of Arcaloy 308L-15 gives the highest resistance to cracking and excellent vertical welding characteristics. Operates on DC current only.

Specifications	
Classifications	AWS A5.4 : E308-15/E308L-15
Approvals	QPL-22200/2 : MIL-308L-15
Industry	Ship/Barge Building Petrochemical Industrial and General Fabrication Tank and Vessel Fabrication

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

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	430 MPa (63 ksi)	520 MPa (90 ksi)	45 %

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	Cu	Ferrite
0.03	1.70	0.55	10	20	0.10	0.10	6 FN