



Stainless Steel Stick Electrodes



Code & Specification

ASME SFA/AWS A5.4 E308L-16

Description

BLUME® E308L-16 is a stainless steel stick electrode. Flux coating provides a smooth arc transfer for all welding positions. Used to weld austenitic steels. Designed with low carbon levels to help eliminate carbide precipitation in high temperature service.

Applications

BLUME® E308L-16 is used to weld type 302, 304 and 308 stainless steels and A743 and A744 type CF-8 cast materials.

Mechanical Properties

	As-welded
Yield Point, MPa	370 - 420
Tensile Strength, MPa	540 - 595
Elongation, %(L=4d)	50 - 55

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	S	P
0.02 - 0.04	0.7 - 2.0	0.30 - 0.60	≤ 0.02	≤ 0.03
Ni	Cr	Mo		
9.5 - 10.5	19.0 - 20.0	0.15 - 0.25		

Packaging

∅ x L	Wt./Carton	Carton/Box	Net wt./Box
2.5mm x 350mm (3/32" x 14")	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)
3.2mm x 350mm (1/8" x 14")	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)
4.0mm x 350mm (5/32" x 14")	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)

Suggested Welding Parameters

∅ x L	AC	DC±
2.5mm x 350mm (3/32" x 14")	40 - 70	40 - 70
3.2mm x 350mm (1/8" x 14")	60 - 100	60 - 100
4.0mm x 350mm (5/32" x 14")	90 - 140	90 - 140

Approvals



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

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