


<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Coated SMAW Electrode</b>  <b>WA TETRA 308L-E</b>	
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### CLASSIFICATION

ASME IIC SFA 5.4 / AWS A 5.4:	E308L-17
EN ISO 3581-A:	E 19 9 L R 1 2
Equivalent Material number:	1.4410
ASME IX Qualification	QW432 F-N° 5    QW442 A-N° 8

### DESCRIPTION

- Rutile-basic coated stainless steel SMAW electrode
- 19% chromium - 9% nickel - low carbon deposit
- Optimum versatility for welding in the flat & horizontal positions with high cosmetic finish
- Excellent weldability in all positions
- Weldable on AC and DC
- High resistance to intergranular corrosion
- Complements Welding Alloys cored wires TETRA S 308L-G and TETRA V 308L-G

### APPLICATIONS

WA TETRA 308L-E is suitable for welding stainless steels with an alloy content between 16 to 21% Cr and 8 to 13% Ni, stabilised or not.

#### Examples:

AISI	UNS	Material number	EN Symbol
302	S30200	1.4300	X12 CrNi 18 8
304	S30400	1.4301	X5 CrNi 18-10
304L	S30403	1.4306	X2 CrNi 19-11
304LN	S30453	1.4311	X2 CrNiN 18-10
305	J92701	1.4312	GX10 CrNi 18-8
308	S30800	1.4303	X4 CrNi 18-12
321	S32100	1.4541	X6 CrNiTi 18-10
347	S34700	1.4550	X6 CrNiNb 18-10

### TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Ni	Fe
0.02	0.7	0.8	19.0	9.5	Bal.

### MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
520	320	30	-20°C:40

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
580	420	42	-20°C:90

### OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350	5.0 x 450
Current [A]	60 -100	80 - 120	100 - 180	120 - 230
= +	~ 70V			

Re-drying: 1h at 250°C, if necessary.

### WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PD, PE, PF, PG  
ASME IX: 1F, 1G, 2F, 2G, 3F, 3G, 4F, 4G, 5G

### PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350	5 x 350
Weight/box [kg]	5.0	5.0	5.0	5.0

Other packaging and other sizes: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.