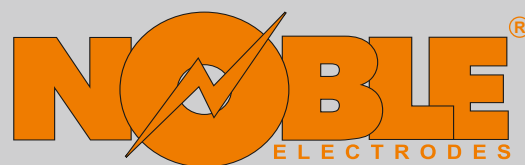


NOBLE - 308

Stainless Steel Electrodes



CLASSIFICATION

AWS - A5.4: E308-16

Characteristics : **NOBLE - 308** is Rutile base, radiographic quality 18-8 stainless steel electrode for resistance to corrosion and cracking. It gives High arc stability and low spatter losses. The resulted weld metal has excellent creep strength and mechanical properties. It works on AC (70 V OCV) as well as DC (+).

Applications : **NOBLE- 308** is suitable for the welding of stainless steel types 301, 302, 304 and 308. It is suitable for Building up surfaces on centrifugal pump impellers and shafts, valve faces, seats, chemical plants, steel furniture etc.

Mechanical Properties

Mechanical Tests	AWS Specifications
Tensile Strength	550 N/mm ² (Min.)
Elongation	35 % (Min.)

* If Moist: Re-dry at 250°C For 1 Hr.

Weld Metal Chemistry (%)

Elements	C	Mn	Si	P	S	Ni	Cr	Mo
Range	0.08 Max	2.5 Max	0.90 Max	0.04 Max	0.03 Max	8 - 11	18 - 21	0.5 Max

Packing Specifications & Current Condition

Size (mm)	Pkts. / Case	Wt. / Pkt	Current (Amp.) AC (70V) DC (+)
2.50 x 350	05	2 Kg.	65 - 90
3.15 x 350	05	2 Kg.	80 - 100
4.00 x 350	05	2 Kg.	100 - 135
5.00 x 350	05	2 Kg.	135 - 180

“Noble – Characterized by all Excellent Qualities”