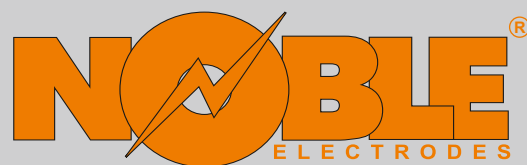


NOBLE - 308L

Stainless Steel Electrodes



CLASSIFICATION

AWS - A5.4: E308L-16

Characteristics : NOBLE - 308L is a Rutile base, low carbon, 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 other mechanical properties. It works on AC (70 V OCV) as well as DC (+).

Applications : NOBLE - 308L is suitable for the welding of stainless steel types 301, 302, 304 and 308 with very low carbon content. 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	520 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 (+)
2.00 x 350	05	2 Kg.	35 - 55
2.50 x 350	05	2 Kg.	50 - 80
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”