

ESAB Stainless Steel Electrodes

ESAB 308L Plus, 316L Plus & 309L Plus

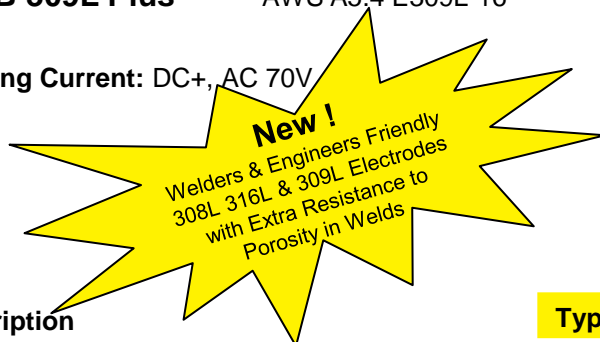
Rutile based low carbon stainless steel electrodes for Shielded Metal Arc Welding

ESAB 308L Plus AWS A5.4 E308L-16

ESAB 316L Plus AWS A5.4 E316L-16

ESAB 309L Plus AWS A5.4 E309L-16

Welding Current: DC+, AC 70V



Description

ESAB Plus series of stainless steel electrodes are rutile based low carbon electrodes for joining stainless steels. ESAB 309L Plus is also suitable for dissimilar joining with unalloyed or low alloyed steels and for transition layers when surfacing mild or low alloyed steel with stainless steel weld metal.

ESAB Plus range of electrodes have easy arc initiation / re-striking characteristics and are resistant to porosity in adverse working conditions.

Type	308L	316L	309L
------	------	------	------

All Weld Chemical Composition (%)

C	0.03	0.03	0.03
Si	0.75	0.70	0.95
Mn	0.65	0.65	0.80
Cr	18.8	18.0	23.7
Ni	9.7	11.8	12.7
Mo	-	2.5	-

All Weld Mechanical Properties

UTS (MPa)	580	580	600
% Elongation	45	38	35

Applications

- General Stainless Steel Fabrication
- Dissimilar Metals Joining
- Surfacing

- Smooth running characteristics
- Stable on both AC & DC welding
- Easy Arc initiation & Re-striking
- Good weld bead appearance
- Resistance to porosity in adverse conditions

ESAB INDIA LIMITED

Registered and Head Office: 13, Industrial Estate, III Main Road, Ambattur, Chennai - 600058.
Tel : 044-42281100 Fax : 044-42281150; Email: info@esab.co.in

Eastern Regional Office
B.T. Road, P.O.: B.D. Sopan,
Khardah, 24 Parganas (N),
Kolkata - 700 116.
Tel: (033) 25532897 /
25638005

Western Regional Office
501/502,5th Floor, Sagar Tech-B
Andheri Kurta Road, Saki Naka
Andheri East, Mumbai 400072
Tel : (022) 2851 7386
Fax : (022) 2852 4974

Northern Regional Office
239 & 240, DLF Tower
Shivaji Marg, Near Karampara
Crossing, New Delhi - 110015
Tel : (011) 4142 7091
Fax : (011) 4142 7099

Southern Regional Office
13, Industrial Estate, III Main
Road, Ambattur,
Chennai - 600058
Tel : (044) 4340 4806
Fax : (044) 4228 1150

Central Regional Office
No. 218, Ashirvad
South Ambazari Road
Bajaj Nagar, Nagpur 440010
Tel : (0712) 222 9547 / 48
Fax : (0712) 222 9549