

DESCRIPTION

Executive stainless steel coated electrodes are a superior operating SMAW filler metal that can be used in a variety of applications. Executive 308/308L is dual certified for both low carbon and standard carbon grades reducing duplication of inventories. Best suited for general purpose welding as the flux coating provides a smooth arc transfer in all positions except vertical down.

Executive 308/308L is a versatile electrode designed to weld several types of austenitic steels with low carbon levels to help eliminate carbide precipitation in high temperature service.

APPLICATIONS & FEATURES

Ideal for welding types 302, 304 and 308 stainless steels, as well as A743 and A744 Type CF-8 cast material.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

| C | Si | Mn | P | S | Cr | Ni |
|------|------|------|------|-------|------|-----|
| 0.02 | 0.60 | 1.10 | 0.03 | 0.010 | 19.0 | 9.6 |

| | | | | | |
|--------------------------|----------------|--------------------|-----|-----------------------|-----------------|
| Tensile Strength: | 76,800 PSI min | Elongation: | 45% | Ferrite Range: | 5-9 FN (WRC-92) |
| Yield Strength: | 56,000 PSI min | | | | |

TYPICAL WELDING PARAMETERS

| Process | Diameter | Length | Amperage |
|-------------|----------|--------|----------|
| SMAW | 3/32" | 12" | 40-70 |
| AC/DC | 1/8" | 14" | 60-100 |
| | 5/32" | 14" | 90-140 |
| | 3/16" | 14" | 120-185 |

STANDARD PACKAGING & HANDLING

| | |
|-------------|--------------------|
| SMAW | 40-lb master box |
| | 10-lb plastic tube |

Executive Stainless electrodes should be stored in their unopened and undamaged original packaging at 18-25°C with 60% max relative humidity. Electrodes slightly affected by moisture may be re-baked for approx. three hours at 250-280°C. Both heating and cooling should be carried out gradually.

The consequences of moisture pick-up are not as serious for stainless steel electrodes as they are for Executive mild steel electrodes.



CLASSIFICATION

AWS/SFA 5.4, Class **E308/308L-16**