XTR Select 308L-16

A5.4 E308L-16

Features & Applications:

XTRweld General-purpose stainless-steel electrode designed for ease of use on types 304L, 301, 302, 303, 308 and 321. Typically used to weld on or repair brewery equipment, food equipment, and pharmaceutical equipment, also for architectural fabrication. The 0.04% maximum carbon content of this electrode preserves the intergranular corrosion resistant properties of the weld.

- Controlled silicon content provides maximum corrosion/ cracking resistance
- "Low hydrogen" manufacturing technology ensures high resistance to weld metal porosity
- High purity core wire gives very low carbon content

Microstructure: Austenite with 3-9% ferrite. Typical ferrite number is 6.

Chemistry:

	Typical	AWS Spec. Single values are max.
Carbon (C)	0.020	0.040
Chromium (Cr)	19.500	18-21
Nickel (Ni)	10.000	9-11
Molybdenum (Mo)	0.750	0.750
Manganese (Mn)	0.800	0.5-2.5
Silicon (Si)	1.000	1.000
Phosphorus (P)	0.020	0.040
Sulphur (S)	0.010	0.030
Copper (Cu)	0.150	0.750

Mechanical Properties: (All weld metal analysis, Typical Weight %)

	Typical	AWS Spec. Single values are min.
Tensile Strength	80,000	75,000 psi
Elongation in 2” (%)	28	30
Charpy V-Notch35J: -157ºF (-105ºC)		ns
Hardness: Brinell 205, Rockwell B94		

Coating	Iron Powder, Titania
Flux Coating, Color	White/Grey

Welding Positions:

F, V, OH, H

Operating Parameters: Coated Electrode/Rod (SMAW), DC Reverse (+) or AC

Formula: 1158

Procedures & results may vary with any change in position, equipment being used, base metal and base metal cleanliness.

Diameter	Amperage Range	Weldmetal Electrode	Electrodes per lb. (kg) of Weldmetal	Arc Time of Deposition min/lb. (kg)	Electrodes (Rods) per Lb. Packaged
1/16 **(1.6mm)**	25-35	.13oz (3.6g)	125 (275)	55 (121)	67
3/32 **(2.4mm)**	55-75	.3 oz. (9g)	50 (109)	35 (76)	28
1/8 **(3.2mm)**	75-110	.7oz (20g)	22 (49)	21 (46)	13
5/32 **(4.0mm)**	90-140	1 oz (29g)	15 (33)	18 (40)	9
3/16 **(4.8mm)**	nr	--	--	--	--
1/4 **(6.4mm)**	nr	--	--	--	--

SCAN for SDS