

# ARCTEC® STAINLESS STEEL ELECTRODES



a quality welding alloy

## ARCTEC® E308L-17 AWS A5.4 Class E308L-17

### DESCRIPTION AND APPLICATION:

Arctec® E308L-17 produces a concave weld bead with minimum ripple and has a virtually self lifting slag. The excellent wetting action and very fine ripple minimize crevice corrosion and grinding time. The low carbon content of this filler metal reduces the risk of carbide precipitation and thus increases the resistance to intergranular corrosion.

For welding types 301, 302, 304 and 308 stainless. Primarily used for welding low carbon base materials of similar composition.

**Typical Mechanical Properties:** Tensile Strength: 83,700 psi (557 MPa) Elongation: 40 -52% - 2"

**Typical Deposit Analysis:**

	C	Cr	Ni	Mn	Si
%	.02	19.0	10.0	.70	.80

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

### Recommended Amperage:

Diameter	1.5 mm 1/16"	2.0 mm 5/64"	2.50 mm 3/32"	3.25 mm 1/8"	4.0 mm 5/32"	5.0 mm 3/16"
Amperage	30-50	40-60	60-80	80-100	110-140	140-180

## ARCTEC® E309L-17 AWS A5.4 Class E309L-17

### DESCRIPTION AND APPLICATION:

Arctec® E309L-17 produces a concave weld bead with minimum ripple and has a virtually self lifting slag. The excellent wetting action and very fine ripple minimize crevice corrosion and grinding time. The low carbon content of this filler metal reduces the risk of carbide precipitation and thus increases the resistance to intergranular corrosion.

For joining and cladding steels of similar composition in wrought and cast form. Also used for welding dissimilar steels such as joining stainless to carbon steel.

**Typical Mechanical Properties:** Tensile Strength: 85,500 psi (586 MPa) Elongation: 35-45% - 2"

**Typical Deposit Analysis:**

	C	Cr	Ni	Mn	Si
%	.02	23.5	13.0	.70	.80

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

### Recommended Amperage:

Diameter	1.5 mm 1/16"	2.0 mm 5/64"	2.50 mm 3/32"	3.25 mm 1/8"	4.0 mm 5/32"	5.0 mm 3/16"
Amperage	30-50	40-60	60-80	80-100	110-140	140-180

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Subject to change without notice

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