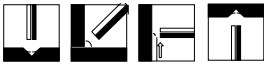




**MANUFACTURERS OF A DIVERSE RANGE OF
ADVANCED WELDING CONSUMABLES**

**SECTION
6**

WI-0304 DS62 NSB-308L Rev. 0, Date 01.09.2008

NSB-308L	FOR WELDING LOW CARBON AUSTENITIC STAINLES STEELS CONTAINING A NOMINAL 19Cr and 10Ni					DATA SHEET NO. 62																																																						
SPECIFICATION	AWS A5.4	BS EN 1600			JIS Z 3221																																																							
CLASSIFICATION	E308L-16	E 19 9 L R			D308L-16																																																							
PRODUCT DESCRIPTION	<p>A metallurgically advanced rutile based flux formulated with balanced additions of chemically basic, amphoteric and acid minerals, together with small alloy additions to compensate for arc losses.</p> <p>The flux is concentrically extruded onto a fully alloyed core wire and bound by a blend of silicates that assures both coating strength and resistance to subsequent moisture absorption.</p>																																																											
WELDING FEATURES OF THE ELECTRODE	<p>This unique flux formulation ensures excellent arc stability, ease of initial arc strike and re-strike minimal spatter on AC and virtually none on DC+. The resultant weld seams are smooth, evenly rippled and free from undercut while slag detachability is excellent. Metal recovery is some 103% with respect to core wire weight.</p>																																																											
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Applications for the electrode are to be found in the Chemical, Petro-Chemical and Cryogenic Processing and Storage Industries as well as the Food, Brewery and Pharmaceutical Industries using the following materials:</p> <table border="0" data-bbox="526 1097 1212 1187"> <tr> <td>ASTM</td> <td>304L</td> <td>304</td> <td>304LN</td> <td>CF3</td> <td>CF8</td> <td></td> <td></td> </tr> <tr> <td>UNS</td> <td>S30403</td> <td>S30400</td> <td>S30453</td> <td></td> <td></td> <td></td> <td></td> </tr> </table> <p>Plus ASTM 301, 302 and 303. For all of the above, NSB-308L ensures matching resistance to corrosion.</p>							ASTM	304L	304	304LN	CF3	CF8			UNS	S30403	S30400	S30453																																									
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WELDING AMPERAGE AC or DC+	Ø (mm)	2.0	2.6	3.2	4.0	5.0																																																						
	MIN	35	65	80	120	160																																																						
	MAX	80	100	125	170	210																																																						
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour.																																																											
RELATED PRODUCTS	Please contact our Technical Department for detail.																																																											