NSD-308L

FOR WELDING LOW CARBON AUSTENITIC STAINLES STEELS CONTAINING A NOMINAL 19Cr and 10Ni

DATA SHEET NO. 61

SPECIFICATION	AWS A5.4	BS EN 1600	JIS Z 3221
CLASSIFICATION	E308L-15	E19 9 L B	D308L-15

PRODUCT DESCRIPTION

A chemically basic flux with a low level of silicious minerals together with small alloy additions to compensate for arc losses.

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.

WELDING FEATURES OF THE ELECTRODE

Suitable for use on DC+ only, the arc is very forceful but the nature of the molten slag allows easy vertical up and overhead welding.

Ideal for site welding as the extra shielding gas from the basic minerals ensures safety against porosity, even in windy conditions.

APPLICATIONS AND MATERIALS TO BE WELDED

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:

ASTM	304L	304	304LN	CF3	CF8
UNS	S30403	S30400	S30453		

Plus ASTM 301, 302 and 303

For all of the above, NSD-308L ensures matching resistance to corrosion.

WELD METAL ANALYSIS COMPOSITION % BY Wt.

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe	FN
MIN	-	0.5	-	-	-	18.0	9.0	-	-		3.0
MAX	0.04	2.5	1.0	0.03	0.04	21.0	11.0	0.75	0.75		5.0
TYPICAL	0.03	1.0	0.5	0.01	0.02	19.5	10.5	0.10	0.12	Bal.	4.0

WELD METAL PROPERTIES (ALL WELD METAL)

PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS
Tensile strength	N/mm^2	520	600	Lateral expansion 0.38 to 0.45 mm. Batch tested for Charphy >0.38 mm Lateral expansion.
0.2% Proof stress	N/mm^2	-	400	
Elongation on 4d	%	35	45	
Reduction of Area (RA)	%	-	43	
Impact energy -196°C	J	-	40	

WELDING AMPERAGE 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.