STAINLESS STEEL

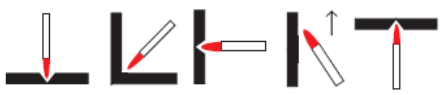
GLST-308L ELECTRODE

Classification : AWS A5.4 E308L-16
EN E 19 9 L R 12
ISO 3581 B-ES308L-16

Characteristics and Application:

GLST-308L is a stainless stick electrode for all-position welding, containing low C-18Cr-8Ni in the deposited metal to secure great mechanical properties. Its low carbon content of weld metal can provide good corrosion resistance. Stable arc, less spatter, smooth weld bead appearance, easy slag detachability and excellent radiographic test result can be obtained. Widely used in petrochemical, pressure containers, food machinery, medical equipment, chemical fertilizers, and other related sectors, such as 00Cr19Ni10(SUS304L).

Welding Postion :



Chemical Composition of Deposited Metal :

Element wt%	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
AWS	0.04	0.5-2.5	1.00	18.0-21.0	9.0-11.0	0.75	0.040	0.030	0.75
Type Value	0.02	1.17	0.54	20.2	9.5	0.11	0.015	0.005	0.049

Mechanical Property of Deposited Metal :

	Yield Stess MPa	Tensile Strength MPa	Elongation %	Charp V-notch J/℃
AWS	-	520	30	-
Typical	500	675	36	-

Notes on Usage:

1. Dry the stick electrodes at 300-350°C for one hour before welding. Do not dry them twice to avoid detachment of covering.
2. Be sure to remove moisture, oil and rust on the base metal.
3. Try to reduce heat input.
4. Choice of current: I= (25~40)*D; D means diameter of stick electrode.
5. Keep short arc length when welding to prevent the crack.
6. Control interpass(layer) temperature to make it under 100°C.
7. Remove the slag after each welding process.
8. When using AC, the stick electrode will become hot easily and there will be more spatter during welding process. The situation can be improved by using

Sizes and Recommended Parameters:

Diameter and Length/mm		2.0×350	2.6×350	3.2×350	4.0×350	5.0×350
Current/Amp	F	30-55	50-85	80-120	100-150	140-180
	V, OH	20-50	45-80	70-110	90-135	-