



# Cromarod 308L

SMAW - (Stick) - MMA  
Stainless Steel

Date: 2003-02-07  
Revision: 20

## Description:

Cromarod 308L is a rutile flux coated AC/DC electrode designed for the welding of low carbon 18%Cr / 10%Ni, type 304L, austenitic stainless steels. Operability is excellent with a low spatter arc producing a smooth weld bead surface and self-releasing slag. The electrode is all-positional up to and including 3.25 mm diameter. Cromarod 308L is also suitable for welding stainless steel grade 304 material, as well as Nb or Ti stabilised grades 347 and 321, when resistance to corrosion is primarily required. For structural applications at temperatures above 400°C, Cromarod 308H is recommended because of its superior strength at elevated temperatures.

## Welding positions:



## Coating type:

Rutile

## Welding current:

DC +, AC 0CV > 39V

## Ferrite content:

FN 7 (WRC-92)

## Corrosion resistance

Good resistance to general and intergranular corrosion. Also good resistance to oxidising acids and cold reducing acids.

## Scaling temperature:

Approx. 850°C in air.

## Redrying temperature:

350°C, 2h

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			18,0	9,0
Typical	0,02	0,8	0,7	0,02	0,02	20,0	10,0
Max	0,030	0,90	2,0	0,025	0,025	21,0	11,0

	Mo	Cu	V	Nb
Min				
Typical	0,1			
Max	0,5	0,5	0,1	0,1

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 N/mm <sup>2</sup>	450 N/mm <sup>2</sup>
Tensile Strength, Rm:	≥ 550 N/mm <sup>2</sup>	580 N/mm <sup>2</sup>
Elongation, A5	≥ 35%	39%
Impact energy, CV:	-20°C • ≥ 50 J	-20°C • 60 J -120°C • 45 J

## Product data

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/kg electrodes	No. of electrodes/kg weld metal	Kg weld metal/hour arc time	Burn-off time/electrode (sec.)
1,60	300	74301600	25-45	27	0,55	230	0,4	35
2,00	300	74302000	35-60	28	0,62	143	0,7	31
2,50	300	74302500	40-80	28	0,62	91	1,0	33
3,25	350	74303200	80-120	29	0,64	45	1,5	45
4,00	350	74304000	100-160	30	0,64	31	2,0	55
4,00	450	74304045	100-160	30	0,64	23	2,0	70
5,00	450	74305000	140-220	30	0,62	15	2,8	79

## Classification:

EN 1600-97	E 19 9 L R 12
AWS A5.4-92	E 308L-17
BS 2926-84	19.9.L R
DIN 8556-86	E 19.9 L R 23
NF A81-343-79	EZ 19.9 L R 23

## Approvals:

UDT	
INSPECTA	
DB	Kennblatt Nr. 30.042.04
TÜV	
SVK	
DNV	
CL	
ABS	

## Note

Core wire:
P ≤ 0.020%
S ≤ 0.015%
N ≤ 0.080%