

# Manual Metal Arc Electrodes

## Stainless Steel MMA Electrodes

### Nicrex E308L

SFA/AWS A5.4-92 E308L-17  
EN 1600 E 19 9 LR 12



#### Description and applications

An acid-rutile coated electrode for the high quality welding of stainless steels of the 19% chromium, 9% nickel type. Emphasis on welder appeal has resulted in an electrode which strikes and re-strikes easily. A smooth, quiet arc offers excellent manipulation and a neat, finely rippled weld profile.

#### Approvals

CE EN 13479

#### All-weld metal properties

	Composition wt %	
	Min	Max
C		0.03
Si	0.50	1.00
Mn	0.50	1.20
S		0.02
P		0.025
Cr	18.5	20.5
Ni	9.0	11.0
Mo		0.05
Cu		0.05

#### AWS

##### Mechanical

0.2% PS  
UTS  
Elongation  
  
Charpy V impact values  
Ferrite level

##### As-welded

320 min N/mm<sup>2</sup>  
520-700 N/mm<sup>2</sup>  
33 min %  
  
at +20°C 47 min ave J  
FN 3-10

Current range	AC (min OCV 50) or DC +
Size (mm)	2.5 3.2
Current (amps)	50-90 70-130