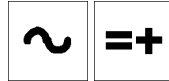


Coating type:
Rutile

Current:



Welding positions:



Tip colour:

-

Printing:

Hilchrome 308L / E308L-17

Hilchrome 308L is our rutile coated electrode for welding low carbon 18Cr10Ni austenitic stainless steel grades like AISI 304, 304L. Typical applications include all industries where similar materials (incl. higher carbon types) as well as ferritic 13% Cr steels are used. Hilchrome 308L is also suitable for Nb (Cb) or Ti stabilised grades 347 and 321. Weld metal has an excellent resistance to general and intergranular corrosion (up to 350°C), good resistance to oxidising acids and cold reducing acids. Hilchrome 308L is a core wire alloyed all-current type (AC/DC).

Base materials to be welded:

- ASTM/AISI Grade 304, 304L, 304LN, 321, 347
- WNr 1.4301, 1.7 1.4311, 1.4541, 1.4311, 1.4300
- CrNi 18 10 and similar stainless steel grades

Applications:

- Shipbuilding & Offshore
- Power Generation
- General fabrication & construction
- Repair & Maintenance
- Process Industry

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	Hilchrome G308LSi	-	Hilchrome W308L	-	-

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	Cr	Ni
0,02	0,6	0,8	19,5	10,1

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 440	≥ 570	≥ 37	+20°C ≥ 60 -40°C ≥ 55

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,0	300	12,3	30-60
2,5	350	21,2	40-80
3,2	350	34,7	70-120
4,0	350	66,7	90-160