



AMERIARC

Ameri 308L-16

INTERNATIONAL CLASSIFICATIONS

AWS A 5.4: E308L-16

DIN 8556: E19.9 L R26

EN 1600:E19 9 L R 32

DESCRIPTION & APPLICATION:

Ameri 308 A1 is a high quality rutile type stainless steel electrode designed for ease of use on types 304L,301,302,303 & 321.

Electrode for joint welding on low carbon, unstabilised and stabilized austenitic, good resistance to oxidising acids. for impact resistant austenitic steels, also for alloyed-similar claddings.

A wide usage in the pressure vessel, process plant, dairy & food industries.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe
.02	.8	1.0	.01	.02	19.5	10.1	.75	.05	bal

Flux Color : White-Grey

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	78,000 PSI (540 MPa)
Yield Strength	62,500 PSI (430 MPa)
Elongation	38%
Hardness	Brinell 205

WELDING CURRENT & INSTRUCTIONS

Recommended Current : DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	55	75	90
Maximum Amperage	75	110	140

PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	2.5	3.25	4.0
	Length (mm)	12" (300)	14" (350)	14" (350)
Packaging	Electrodes /lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0