

SUPRANOX RS 308L T is a rutile electrode for all position welding of 18-8 austenitic stainless steels with service temperatures down to -196°C with controlled composition and ferrite content (WRC-92) an >0.38mm lateral expansion.

It is particularly suitable for pipework and vessels subject to cryogenic service (-196°C) applications. Better weldability, superior results with softer transitions to the parent metal and improved slag removal are some of the advantages of the rutile types vs. basic solutions.

Classification

EN ISO	3581-B; ES 308L-16
AWS	A5.4; E 308L-16

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Ferrite
0,025	1,0	0,8	≤ 0,025	≤ 0,015	18,7	9,8	3-6

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				-100 °C	-196 °C
As Welded	≥ 420	≥ 520	≥ 35	>40	>27

Materials

304-304L-304LN-CF3-CF8

1,4301; 1,4306; 1,4307; 1,4308; 1,4311; 1,4541

S 30403; S30400; S30453

Storage

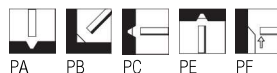
Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 250-300°C for 1 hour, 5 times max.

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	VPM D	
				PC	Code
2,5	300	60-80	18,7	90	W000380843
3,2	350	75-130	34,1	60	W000380820
4,0	350	90-160	50,5	40	W000380822
5,0	350	130-200	78,7	25	W000380824