



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE
1137
Blue 308L-16

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 308L-16 EN 1600: E 19 9 L R 32
DIN 8556: E19.9LR 26 ISO 3581 E19.9 L R 32
NFA 81-343: EZ 19.9 LR 26 BS 2926 - 1984 19.9L R

FEATURES & APPLICATIONS

Use on typical brewery, food, and pharmaceutical equipment, also for architectural fabrication.

General purpose stainless steel electrode designed for ease of use on types 304L, 301, 302, 303, 308 and 321.

- Controlled silicon content provides maximum corrosion/ cracking resistance.
- "Low hydrogen" manufacturing technology ensures high resistance to weld metal porosity.
- High purity core wire gives very low carbon content.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Austenite with 3-9% ferrite. Typical ferrite number is 6.

Flux Color: Blue

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe
.02	.8	1.0	.01	.02	19.5	10	.75	.05	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal **Maximum Value Up to:**
Tensile Strength 77,500 PSI (530 MPa)

Yield Strength	54,000 PSI (370 MPa)
Elongation	38%
Impact Energy	35J: -157°F (-105°C)
Hardness	Brinell 205, Rockwell B94

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	1/16 (1.6)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	25	30	55	75	90
Maximum Amperage	35	50	75	110	140

Welding Techniques: Material to be welded should be clean of all contaminants. Maintain a short arc and use stringer beads rather than a weave technique.

Welding Positions: Flat, Horizontal, Vertical up, Overhead

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/ lb (kg)	Amperage Settings	Recovery Rate
1/16 (1.6)	10" (250)	.13oz (3.6g)	125 (275)	55 (121)	30	100%
5/64 (2.0)	12" (300)	.14oz (4g)	114 (251)	47 (103)	40	100%
3/32 (2.5)	12" (300)	.3 oz. (9g)	50 (109)	35 (76)	65	100%
1/8 (3.25)	14" (350)	.7oz (20g)	22 (49)	21 (46)	95	100%
5/32 (4.0)	14" (350)	1 oz (29g)	15 (33)	18 (40)	120	100%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/16 (1.6)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
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Length (mm)	10" (250)	12" (300)	12" (300)	14" (350)	14" (350)
Electrodes / lb	67	42	28	13	9
Electrodes / kg	147	92	62	29	20