



Manufacturers of Custom Welding Lines for Resale
www.selectrode.com

SELECTRODE 6308 308L Flux Coated Tig

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.9 ER 308L

EN 12072: W 19 9 L

FEATURES & APPLICATIONS

6308 TIG rod is an extremely low carbon stainless steel Alloy with molybdenum added to provide superior corrosion resistance. It is especially well suited for welding stainless steel pipe wherever a backing ring or a purge gas is required in order to provide impurity free weldments. This is necessary during stainless steel pipe welding in the chemical and petro-chemical industries.

A special 308L TIG alloy coated with our unique Vari-Flow fluxing system

- A very special TIG wire that eliminates the expense and wasted time associated with purging pipes with inert backing gasses
- Easy to handle 18 inch (450mm) length works in multiple positions without having to bend the wire.
- Can be ordered in grade 316L as item number 6316.
- Any other grade of stainless can be manufactured in 100 pound (45kg) per diameter minimum quantities.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

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

Flux Color: Yellow

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe
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.02	1.71	.35	.005	.02	20.4	10	.60	.05	bal
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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 Straight (-)

Recommended Amperage Settings:

Diameter (mm)	3/32 (2.5)	1/8 (3.25)
Minimum Amperage	60	80
Maximum Amperage	100	120

Welding Techniques: Clean weld surface carefully to remove all scale and corrosion. Sections over 3mm should be beveled to permit complete penetration. Clean joint surface using a stainless steel brush. Use DC - (straight polarity), 2% thoriated tungsten electrode.

Welding Positions: Flat, Horizontal, Vertical up

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/Rod	Rods per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Setting	Recovery Rate
3/32 (2.5)	18" (450)	1.5oz (44g)	10 (22)	21 (46)	80	93%
1/8 (3.25)	18" (450)	2.0oz (58g)	8 (18)	18 (40)	100	93%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)
Length (mm)	18" (450)	18" (450)
Electrodes / lb	14	10
Electrodes / kg	31	22