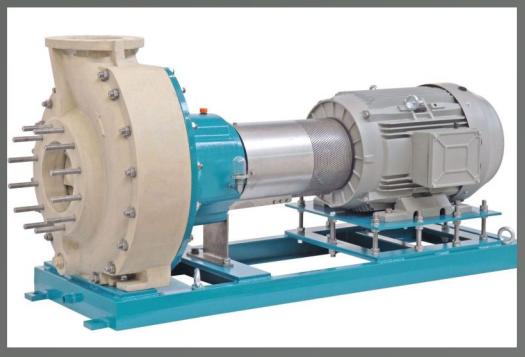
Stainless Steel Electrodes (MMAW)

SME 308-16



SENOR®

One Stop Solution for Welding & Brazing Consumables

SME 308-16 | Stick Electrodes (MMAW) | Stainless Steel

Classifications:

AWS SFA 5.4/SFA 5.4M : E 308 - 16
UNS Number : W30810
EN ISO 3581-A : E 19 9 R 32

Characteristics:

SME 308-16 composition of the weld metal is 19.5Cr, & 10Ni, electrodes of this composition are most often used to weld base metal of similar composition such as AISI Types 301, 302, 304, and 305. E308-16 electrodes provide corrosion resistance and physical properties equal to or greater than the steels for which they are recommended.

Applications:

1. Used to weld base metal of similar composition, Typical applications include dairy, distillery and restaurant equipment, and chemical tanks.
2. SME308-16 is designed for welding of the following 18-8 stainless steel types: 301, 302, 304 and 308.
3. The weld deposit has the proper chemical content and balance for satisfactory welding of type 308,
4. Suitable for welding 18-8 types of lower alloy content. Sound weld metal.

Mechanical Properties – All-Weld:

Tensile Strength min – 520 MPa
Elongation – 30 %

Weld Metal Chemistry (wt%):

C	**Cr**	**Ni**	Mo	Mn	**Si**	**P**	**S**	**Cu**
0.08 max	18 - 21	9 - 11	0.75 max	0.5 - 2.5	1.0 max	0.04 max	0.03 max	0.75 max

Current Conditions: AC, DC (+):

2.5	**3.15**	**4.0**	5.0
50 - 75	80 - 100	120 - 150	170 - 190

Re-drying Conditions:

To obtain best results Re-dry the Electrodes at 300°C for 1hour (optionally available in vacuum packed Condition, re-drying not required in this packaging)

Note On Usage:

1. Use Stainless Steel Wire brush, Clean the area to be weld.
2. Maintain Pre Heat and Inter pass Temperature up to 150°C.
3. To obtain best results re bake the electrodes at 300°C for 1 hour and keep it at 100°C to 150°C Prior to use.
4. Follow the recommended welding parameters to achieve good sound welds.
5. Do not use excessive currents. Hold short arc, Use good fit up on Joints.

Above are basic guidelines and will vary depending on joint design, number of passes and other factors.

WARNING

Protect yourself and others. Read and understand this warning. Do not remove this warning.

Fumes and Gases can be hazardous to your health

- Before use, read and understand the Material Safety Data Sheet (MSDS), the manufacturer's instructions, and your employer's safety practices.
- If MSDS is not enclosed. Obtain from your employer.
- Keep your head out of the fumes. See Section 5 of the MSDS for specific fume concentration limits.
- Use enough Ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area. If needed, use a proper respirator.
- No hazards exist before this product is used in arc welding.

Electric Shock can kill

- Always wear dry insulating gloves
- Insulate yourself from work and ground.
- Do not touch live electrical parts.

ARC Rays can injure eyes and burn skin

- Wear welding helmet with correct filter.
- Wear correct eye, ear, and body protection.

Welding can cause fire or explosion

- Do not weld near flammable material.
- Watch for fire, keep, extinguisher nearby.

Read American National Standards Z49.1, "Safety In Welding, Cutting and Allied Process." from American Welding Society.