

Standards:		capilla® 308 L
EN ISO 3581-A:	E 19 9 LR 12	
EN 1600:	E 19 9 LR 12	
AWS A 5.4:	E 308 L-16	
Mat.-No.:	1.4316	
Approvals:	TÜV, DB	

Product description:	Applications:
Rutile-basic coated stick electrode for welding of non-stabilized austenitic stainless Cr-Ni steels with extra low carbon content; suitable for service temperatures of up to 350°C; good low temperature properties down to -196°C.	Suitable for materials as: 1.4300, 1.4301, 1.4303, 1.4306, 1.4308, 1.4311, 1.4312, 1.4371, 1.4541, 1.4543, 1.4550, 1.4552.

Typical weld metal composition:
[wt. - %]

	C	Cr	Ni	Fe
Min.		18	9	
Max.	0,03	20	11	Bal.

Mechanical properties: (without heat treatment; minimum values at ambient temperature)	
Tensile strength R _m :	550 [MPa]
Yield strength R _{p0,2} :	320 [MPa]
Yield strength R _{p1,0} :	- [MPa]
Elongation (L=5d):	35 [%]
Impact strength (ISO-V):	70 [J]

Positions:	all except PG
Redrying:	300°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	2,0	300	40 – 60	=(+)~
	2,5	300	50 – 90	
	3,25	350	80 – 110	
	4,0	350	100 – 150	
	5,0	450	150 – 200	

also available: find in table of content	Capilla 308 H Capilla 308 KB Capilla 308 LR	Capilla 308 L MAG Capilla 308 L WIG Capilla G 308 L RM (tubular wire)
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