

Standards:

EN ISO 3581-A: E 19 9 LR 12
 EN 1600: E 19 9 LR 12
 AWS A 5.4: E 308 L-17
 Mat.-No.: 1.4316

Approvals:

TÜV

capilla® 308 LR**Product description:**

Rutile 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 -78°C.

Applications:

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 L

Capilla 308 L MAG
 Capilla 308 L WIG
 Capilla G 308 L RM (tubular wire)