

SB ZULFI E 308L-15

Brand Name & Classification

AWS/ASME SFA-5.4:E 308L-15
DIN 8556: E 19 9 LB 20

Approvals Grade

Properties

Austenitic stainless steel electrode suitable for welding of austenitic Cr-Ni steels of low carbon content as well as cast steels. Suitable for operating temperatures up to +350° c. Slag removal easy.

Application

1.4306: X 2 CrNi 19 11	1.4301: X 5 CrNi 18 10
G-X 2CrNiN 18 9	1.4303: X 5CrNi 18 12
1.4311: X 2CrNiN 18 10	1.4308: X G-X 6 CrNi 18 9
1.4541: X 6 CrNiTi 18 10	1.4310: X 12 CrNi 17 7
1.4550: X 6 CrNiNb 18 10	1.4319: X 5 CrNi 17 8

Weld Metal Analysis Typical values

Carbon: 0.03

Silicon: 0.40

Manganese: 1.00

Chromium: 19.0

Nickel: 10.0

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>400 N/MM2	550 - 620 N/mm2	> 35 %	75 J at +20° c

Welding Current & Positions



Current

Dia	Length	Amperes
2.5	300	45-80
3.2	350	50-125
4.0	350	90-150