



# USA 308L-16 Coated Electrode

U.S. ALLOY CO.  
dba Washington Alloy  
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WASHINGTON ALLOY'S Quality  
Management System is  
Certified to **ISO 9001:2008**  
Cert # 05-R0925



## ALLOY DESCRIPTION AND APPLICATION;

USA 308L electrodes contain extra low carbon for the welding of austenitic, low carbon 18% Cr – 8% Ni stainless steels such as AISI-304-ELC. The weld deposit of this electrode contains a maximum of 0.04% carbon, which greatly reduces the formation of chromium carbides, thereby protecting the corrosion resistant qualities of the base metal and weld. USA 308L electrodes have a high deposition rate resulting in excellent efficiency. This electrode may be used in all positions. In addition to 304-ELC, USA 308L electrodes may be used for stabilized stainless steels such as AISI 321 and 347, joint welds in construction parts for chemical engineering and cryogenic applications.

## TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps	Diameter	Amps
1/16"	15-40	1/8"	75-110
5/64"	30-50	5/32"	100-140
3/32"	50-75	3/16"	160-200

Arc Length = short arc, Flat use 15° angle from 90°, Vertical up & Overhead use weaving techniques within puddle

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.  
When welding vertical reduce amperage 10-20%

## TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Carbon	0.030	Phosphorus	0.018
Manganese	1.03	Sulfur	0.010
Silicon	0.40	Nickel	10.20
Chromium	19.58		
	Elongation		46%
	Yield Strength (psi)		55,000
	Tensile Strength (psi)		80,000

Iron balance and all single values are maximum percentages

**AVAILABLE SIZES:** TF308L-16 = 1/16", 5/64", 3/32", 1.8", 5/32", 5/32"

**SPECIFICATIONS;** ANSI/AWS A5.4 E308L-16  
ASME SFA 5.4 E308L-16



2012 DC

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