

DESCRIPTION

NSS-308L is a lime-titania type electrode, which shows 19%Cr-9%Ni austenitic weld metal virtually free from spatter. It is superb in usability. It is excellent in heat and corrosion resistance. It is widely used for various chemical and food processing industry and buildings in austenitic stainless steel job. Peeling-off of the slag is very good.

APPLICATIONS

Welding of AISI304 stainless steel. Welding of AISI301, AISI302 stainless steel.

INSTRUCTION FOR WELDING

- (1) Keep the arc length as short as possible.
- (2) Choose the welding current within the range stated in the table below.
- (3) Do not use excessive current.

Typical Chemical Composition of Weld Metal (%):

C	Si	Mn	Cr	Ni	Mo
0.02	0.40	1.85	19.59	10.35	-

Typical Mechanical Properties of Weld Metal:

Tensile Strength N/mm2 (Ksi)	Elongation (%)
567 (82)	47

Size and Recommended Current Range (AC or DC +):

Diameter (mm)	1.6	2.0	2.5	3.2	4.0	5.0	
Length (mm)	255	255	300	350	350	350	
Ampere	Flat	20-50	20-50	50-80	70-110	100-150	130-180
	V&OH	15-45	15-45	45-75	65-105	95-140	-

Welding Positions:

FLAT, FILLET, VERTICAL UP, HORIZONTAL, OVERHEAD

APPROVALS: ABS

Packing:

EXPORT (1.6-2.5mm): 16 Kg corrugated box, with 4 units of 4 Kg plastic container.

EXPORT (3.2-5.0mm): 20 Kg corrugated box, with 4 units of 5 Kg plastic container.

LOCAL: 5Kg Special Paper Box with shrink wrapped plastic

Special requests on packing are accepted.