

Classifications

high-alloyed

EN ISO 3581-A:

AWS A5.4:

E 19 9 L R

E308L-17

Characteristics and field of use

Avesta 308L/MVR is a Cr-Ni electrode for all position welding of 1.4301/ASTM 304 type stainless steels. Corrosion resistance: Very good under fairly severe conditions, e.g. in oxidising acids and cold or dilute reducing acids.

Base materials

Outokumpu	EN	ASTM	BS	NF	SS
4301	1.4301	304	304S31	Z7 CN 18-09	2333
4307	1.4307	304L	304S11	Z3 CN 18-10	2352
4311	1.4311	304LN	304S61	Z3 CN 18-10 Az	2371
4541	1.4541	321	321S31	Z6 CNT 18-10	2337

Typical analysis of all-weld metal (Wt-%)

C	Si	Mn	Cr	Ni
0.02	0.8	0.6	19.5	10.0

Ferrite 8 FN; WRC-92

Mechanical properties of all-weld metal

Heat Treatment	Yield strength 0.2%	Tensile strength 1.0%	Elongation ($L_0=5d_0$)	Impact values in J CVN		
	MPa	MPa	%	+20°C:	-40°C:	-196°C:
untreated	440	570	37	60	40	27

Operating data



Polarity = + / ~

Dimensions (mm)

Amperage A

2.0 x 300	30-55
2.5 x 350	45-70
3.25 x 350	60-110
4.0 x 450	90-150
5.0 x 450	140-200