

## CLASSIFICATION

EN 1600 : E 19 9 LR 12      Werkstoff-Nr : 1.4306  
AWS A5.4 : E308L-16

## GENERAL DESCRIPTION

LSN-308L is an extra low carbon rutile coated electrode. It gives a filler metal of the Cr-Ni type. Excellent quality smooth weld beads are highly resistant to acids, intergranular corrosion at operating temperatures up to 350°C, and to oxidation up to 800°C. It gives a stable arc and the slag is easy to remove.

## APPROVALS

CE, GOST, SEPRO, TSE, TÜV

ABS      BV      DNV      GL

E308L-16    308L    NV 308L    4306

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn	Cr	Ni
0.03	0.80	0.70	19.00	10.00

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 420 N/mm <sup>2</sup>
Tensile Strength	: 570 N/mm <sup>2</sup>
Elongation (L=5d)	: 45 %
Impact (ISO-V)	: 80 J (+20°C)

## APPLICATIONS AND MATERIALS TO BE WELDED

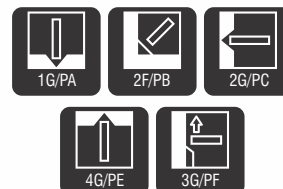
In addition to the welding of steels corresponding to AISI 301, 302, 304, 304L, 308 and 308L; LSN-308L can also be used in the welding of niobium or titanium stabilized austenitic stainless steels. Welding of vapor and pressure fittings, storage tanks and equipment that are used in milk and other food industries, stainless steel or stainless steel plated steels operating under chemical attack are among its application areas. It is an ideal electrode for the joining of stainless steel parts (having similar chemical composition with the electrode) with steel cast pieces. Up to and including 3.25 mm diameter electrodes can be used in all positions; whereas 4 mm and 5 mm electrodes should be used in the flat position.

	EN 10088-1/-2	EN 10213-4	W. Nr
<b>Extra Low Carbon Stainless Steels (C &lt; %0.03)</b>	X2 CrNi 19 11	-	1.4306
	X2 CrNiN 18 10	-	1.4311
<b>Medium Carbon Stainless Steels (C &gt; %0.03)</b>	X4 CrNi 18 10	-	1.4301
	X4 CrNi 18 12	-	1.4303
	-	G-X5 CrNi 19 10	1.4308
<b>Stabilized Stainless Steels (Nb/Ti)</b>	X6 CrNiTi 18 10	-	1.4541
	X6 CrNiNb 18 10	-	1.4550
	-	G-X5 CrNiNb 19 10	1.4552

## WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : AC min 50 V ; DC (+)

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
2.00	250	45 - 60	990	1.6 / 160	1.5
2.50	250	60 - 80	1660	1.6 / 40	1.5
3.25	300	75 - 115	3230	2.1 / 65	2.0
4.00	350	115 - 150	5420	2.2 / 40	2.5
5.00	350	140 - 160	8112	2.1 / 25	2.5



**Liability** : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.  
**Fumes** : Consult information on Welding Safety Sheet, available upon request.

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