

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY308LA

● Applicable Specification

JIS Z 3221 ES308L-16
AWS A5.4 E308L-16

● Identification Color

End Face: Red
Side Face: Black

● Applications and Characteristics

TASETO RNY308LA is designed to suppress the ferrite content in weld metal with excellent low temperature impact strength.

It is used for welding of equipment that for extra low temperature environment including liquid hydrogen, liquid nitrogen, and liquid helium.

RNY308LA is a lime-titania type electrode suitable for positional and its weld metal has good hot cracking resistibility.

● Notes on Usage

- * Dry the electrode at 150°C to 200°C for 60 minutes before use.
- * Remove oil and dust from the surface to be welded.
- * Keep interpass temperature at 120°C or less.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.027	0.33	1.725	0.018	0.006	11.29	19.70	0.09	0.10

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	413	568	40.1

● Impact Properties of All Weld Metal

	Absorbed Energy (J)			Lateral Expansion (mm)
	20°C	-100°C	-196°C	-196°C
Typical	113	67	48	0.83

● Other Properties of All Weld Metal

- * Typical Ferrite Content : 3.6% (Schaeffler's Diagram)

● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
2.6	300	50~90	45~80
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—