

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY308L3

● Applicable Specification

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

● Identification Color

End Face: Red
Side Face: Red

● Applications and Characteristics

TASETO RNY308L3 is the electrode is the same composition as that of RNY308L. But carbon content of all weld metal is suppressed as low as 0.030% or less. Because of good resistibility for intergranular corrosion, it is suitable for welding of Type 304L plate or castings for important chemical equipment impracticable of solution heat treatment.

RNY308L3 is a lime-titania type covered electrode suitable for positional welding.

● 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 to minimize the carbon content in weld metal.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.025	0.45	1.49	0.020	0.006	9.90	19.52	0.09	0.10

● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy at 20°C (J)
Typical	562	42.2	96

● Other Properties of All Weld Metal

* Typical Ferrite Content : 8.5% (Schaeffler's Diagram)

* 65% Nitric Acid Test : max. 0.001 in/month

* Copper Sulfate-Sulfuric Acid Test : No defects after Bending (650°C × 2h PWHT)

● Sizes Available, Recommended Welding 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	—