

# TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

## RNY308

### ● Applicable Specification

JIS Z 3221 ES308-16

AWS A5.4 E308-16

### ● Identification Color

End Face: Yellow

Side Face:—

### ● Applications and Characteristics

TASETO RNY308 is the electrode designed for Type 304 stainless steel.

RNY308 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.

\* Use welding current as low as possible to reduce intergranular corrosion.

### ● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.057	0.46	1.34	0.023	0.005	9.90	19.98	0.09	0.12

### ● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy at 20°C (J)
Typical	610	43.2	103

### ● Typical Mechanical Properties of All Weld Metal in Elevated Temperatures

Temperature (°C)	Tensile Strength (MPa)
550	372
650	308
725	234
800	173

### ● Other Properties of All Weld Metal

\* Typical Ferrite Content : 7.3% (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	—