

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY308L

● Applicable Specification

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

● Identification Color

End Face: Red
Side Face: —

● Applications and Characteristics

TASETO RNY308L is designed for welding of Type 304L, with excellent intergranular corrosion resistance by suppressing the carbon content in its all weld metal. This electrode is suitable for welding of corrosion-resisting containers where solution heat treatment is impracticable.

RNY308L is a lime-titania type electrode and applicable 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.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.030	0.52	1.58	0.021	0.006	9.92	19.05	0.11	0.11

● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy at 20°C (J)
Typical	571	43.0	103

● Typical Mechanical Properties of All Weld Metal in Elevated Temperatures

Temperature (°C)	Tensile Strength (MPa)
550	336
650	279
725	220
800	200

● Other Properties of All Weld Metal

* Typical Ferrite Content : 7.0% (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 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	—