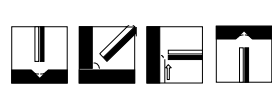


<b>NSB-308L</b>	<b>FOR WELDING LOW CARBON AUSTENITIC STAINLES STEELS CONTAINING A NOMINAL 19Cr and 10Ni</b>					<b>DATA SHEET NO. 62</b>																																																					
SPECIFICATION	AWS A5.4	BS EN 1600		JIS Z 3221																																																							
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PRODUCT DESCRIPTION	<p>A metallurgically advanced rutile based flux formulated with balanced additions of chemically basic, amphoteric and acid minerals, together with small alloy additions to compensate for arc losses.</p> <p>The flux is concentrically extruded onto a fully alloyed core wire and bound by a blend of silicates that assures both coating strength and resistance to subsequent moisture absorption.</p>																																																										
WELDING FEATURES OF THE ELECTRODE	<p>This unique flux formulation ensures excellent arc stability, ease of initial arc strike and re-strike minimal spatter on AC and virtually none on DC+. The resultant weld seams are smooth, evenly rippled and free from undercut while slag detachability is excellent. Metal recovery is some 103% with respect to core wire weight.</p>																																																										
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Applications for the electrode are to be found in the Chemical, Petro-Chemical and Cryogenic Processing and Storage Industries as well as the Food, Brewery and Pharmaceutical Industries using the following materials:</p> <table border="0" data-bbox="526 1097 1212 1187"> <tr> <td>ASTM</td> <td>304L</td> <td>304</td> <td>304LN</td> <td>CF3</td> <td>CF8</td> </tr> <tr> <td>UNS</td> <td>S30403</td> <td>S30400</td> <td>S30453</td> <td></td> <td></td> </tr> </table> <p>Plus ASTM 301, 302 and 303. For all of the above, NSB-308L ensures matching resistance to corrosion.</p>						ASTM	304L	304	304LN	CF3	CF8	UNS	S30403	S30400	S30453																																											
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WELD METAL ANALYSIS COMPOSITION % BY Wt.	<table border="0" data-bbox="462 1276 1516 1456"> <thead> <tr> <th></th> <th>C</th> <th>Mn</th> <th>Si</th> <th>S</th> <th>P</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> <th>Fe</th> <th>FN</th> </tr> </thead> <tbody> <tr> <td>MIN</td> <td>-</td> <td>0.5</td> <td>-</td> <td>-</td> <td>-</td> <td>18.0</td> <td>9.0</td> <td>-</td> <td>-</td> <td></td> <td>3.0</td> </tr> <tr> <td>MAX</td> <td>0.04</td> <td>2.5</td> <td>1.0</td> <td>0.03</td> <td>0.04</td> <td>21.0</td> <td>11.0</td> <td>0.75</td> <td>0.75</td> <td></td> <td>5.0</td> </tr> <tr> <td>TYPICAL</td> <td>0.02</td> <td>1.4</td> <td>0.6</td> <td>0.01</td> <td>0.02</td> <td>19.2</td> <td>10.1</td> <td>0.15</td> <td>0.3</td> <td>Bal.</td> <td>4.0</td> </tr> </tbody> </table>												C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe	FN	MIN	-	0.5	-	-	-	18.0	9.0	-	-		3.0	MAX	0.04	2.5	1.0	0.03	0.04	21.0	11.0	0.75	0.75		5.0	TYPICAL	0.02	1.4	0.6	0.01	0.02	19.2	10.1	0.15	0.3	Bal.	4.0
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WELDING AMPERAGE AC or DC+	Ø (mm)	2.0	2.6	3.2	4.0	5.0																																																					
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour.																																																										
RELATED PRODUCTS	Please contact our Technical Department for detail.																																																										