

BASINOX 308 L is a basic coated MMA electrode for welding similar austenitic Cr-Ni steels or cast steels. With the correct welding procedure, applications include the joining of ferritic and stainless Cr-steels. Structural works with 304L stainless steels in all positions except vertical down. The weld metal has high ductility and BASINOX 308L is recommended for welding thicker section components. Applications include wet-corrosive conditions for operating temperatures <350°C, non-scaling <800°C. Easy slag release and well-suited for positional welding.

Classification	
EN ISO	3581-A: E 19 9 L B 22
AWS	A5.4: E 308L-15

Approvals	Grade
DB	●
TÜV	●

CE

## Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Ferrite
≤ 0.03	1.5	0.3	≤ 0.025	≤ 0.025	19	10	5-10

## All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-120 °C
As Welded	≥ 350	≥ 520	≥ 30	≥ 60	≥ 32

## Materials

1.4301 (X4CrNi18-10) - 1.431 (X2CrNi18-10)

1.4541 (X6CrNiTi18-10)

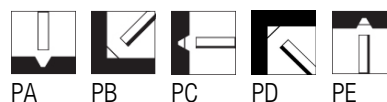
### Storage

Keep dry and avoid condensation.

Re-dry at 250°-300°C for 1 hour, 5 times max.

### Current condition and welding position

DC+



## Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	VPMD	
				PC	Code
2.5	300	45-70	17.48	100	W000287951
3.2	350	65-120	32.8	65	W000287952
4.0	350	100-140	49.5	40	W000287953
5.0	350	130-170	72.1	25	W000287954