

SATINCROME 308L-17

PRODUCT DATA SHEET



**SMOOTH RUNNING,
RUTILE TYPE STAINLESS
STEEL ELECTRODE**

**45
OCV**

**DC
AC**

STAINLESS STEEL AND SPECIAL ELECTRODES

SATINCROME 308L-17

- Rutile Type, Stainless Steel Electrode.
- Outstanding Operator Appeal!
- Now with Improved Slag Lift!
- All Positional (except vertical down) Welding capabilities.
- Advanced Moisture Resistant Flux Coating.
- Packed in Resealable Plastic Tubes.

CLASSIFICATIONS:

ISO AS/NZS 4854:	B ES308L-17
AWS/ASME-SFA A5.4:	E308L-17

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	500 MPa
Tensile Strength	630 MPa
Elongation	40%
CVN Impact Values	75 J av @ +20°C

TYPICAL ALL WELD METAL ANALYSIS:

C:	0.025%
Mn:	0.76%
Si:	0.87%
Cr:	20.4%
Ni:	9.8%
S:	0.010%
P:	0.017%

DESCRIPTION AND APPLICATIONS:

Satinchrome 308L-17 is a smooth running, rutile type stainless steel electrode manufactured by CIGWELD for the all positional (except vertical-down) fillet and butt welding of 19Cr/10Ni type stainless steels.

The features of Satinchrome 308L-17 include high AC arc stability, sound radiographic quality, smooth arc transfer characteristics, very low spatter levels and excellent bead shape and contour. The advanced moisture resistant (MR) flux coating provides improved resistance to start-of-run porosity. Slag lift of Satinchrome 308L-17 is enhanced in all welding positions, it is self peeling and non-spitting.

Applications of Satinchrome 308L-17 include the single and multi-pass welding of 19Cr/10Ni type stainless steel grades including 201, 202, 301, 302, 303, 304, 304L, 305, 308 etc.

COMPARABLE CIGWELD PRODUCTS:

Autocraft 308LSi GMAW wire
AWS A5.9: ER308LSi
Comweld 308L Gas/TIG wire
AWS A5.9: ER308L
Verti-Cor 308LT & FCAW wires
AWS A5.22: E308LT1-1/4

PACKAGING AND OPERATING DATA:

AC (minimum 45 O.C.V.), DC+ polarity.

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	APPROX NO. RODS/KG	CURRENT RANGE (AMPS)	PACK SIZE	CARTON	PART NO.
2.5	300	53	50-90	1.5kg	9kg - 6 x 1.5kg	611602N
3.2	350	28	70-130	2.0kg	12kg - 6 x 2.0kg	611603N

FERRITE NUMBER:

3.0 - 10.0 FN*.

* - USING SEVERN GAUGE.

WELDING POSITIONS:

All positional - except vertical down.

