

NC-308

For welding of 18%Cr-8%Ni stainless steel

AWS A5.4 E308-16
KS D7014 E308-16
JIS Z3221 ES308-16

Applications

Welding of 18%Cr-8%Ni stainless steel such as AISI (SUS) 304.

Characteristics

NC-308 is a lime-titania type electrode for all-position welding. As its deposits austenitic weld metal which contains suitable quantity of ferrite, its crack resistibility and weldability are especially good.

Furthermore, its heat resistibility, corrosion resistibility and mechanical properties are good in the as welded conditions.

Notes on usage

- (1) Keep the arc as short as possible and choose the welding current as low as possible.
- (2) Weaving width should be within two and a half times of electrode's diameter.
- (3) When the electrodes have absorbed moisture, dry them at 250~300℃ for 60~90 minutes before use.
- (4) Usually, preheat is not necessary.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Cr	Ni
0.06	1.10	0.72	0.020	0.006	19.70	9.90

Typical mechanical properties of weld metal

TS N/mm ² (kgf/mm ²)	EL %
600(61)	47

Size & recommended current range (AC or DC +)

Dia. (mm)	2.0	2.6	3.2	4.0	5.0	
	L (mm)	250	300	350	350	350
Amp.	F	30-50	50-80	70-115	100-150	150-200
	V&OH	25-45	45-75	65-110	95-140	-