



## Nexus 308L

### 19%Cr 9%Ni - Stainless Steel electrode for MMA welding

Rutile Stainless Steel Electrode for the joining of stainless steels of a similar composition. Producing butt and mitre finish fillet welds that are smooth and free of spatter.

#### International Standards

<b>BS EN 1600:1997</b>	<b>AWS A5.4 - 06</b>
<b>E 19 9 LR 3 2</b>	<b>E308L-17</b>

#### Typical All-Weld Metal Analysis (wt%)

<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>S</b>	<b>P</b>	<b>Cr</b>	<b>Ni</b>	<b>Ferrite</b>
<b>&lt;0.03</b>	<b>0.8</b>	<b>0.7</b>	<b>0.012</b>	<b>0.015</b>	<b>19.0</b>	<b>9.5</b>	<b>7.0</b>

#### Typical All-Weld Metal Mechanical Properties

<b>Yield Strength N/mm<sup>2</sup></b>	<b>Tensile Strength N/mm<sup>2</sup></b>	<b>Elongation %</b>	<b>Impact Strength +20<sup>o</sup>C</b>
<b>&gt;360</b>	<b>&gt;560</b>	<b>&gt;35</b>	<b>&gt;70</b>

#### Welding Positions

<b>Flat butt weld, flat fillet welds, horizontal vertical fillet welds</b>
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#### Materials

<b>321 and 304L</b>
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#### Packaging

<b>Size mm</b>	<b>2.5 x 300</b>	<b>3.2 x 350</b>	<b>4.0 x 350</b>
<b>Pieces/Packet</b>	<b>135</b>	<b>70</b>	<b>48</b>
<b>Pieces/Carton</b>	<b>540</b>	<b>280</b>	<b>192</b>
<b>Kg/Package</b>	<b>2.5</b>	<b>2.5</b>	<b>2.5</b>
<b>Packs/Carton</b>	<b>4</b>	<b>4</b>	<b>4</b>
<b>Kg/Carton</b>	<b>10</b>	<b>10</b>	<b>10</b>

#### Operating Requirements

<b>DC+ AC (70ocv min)</b>	<b>50 – 80 A</b>	<b>90 – 110 A</b>	<b>120 – 150 A</b>
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#### Additional Information

<b>CE Certified</b>	<b>Constructional products directive (CPD)</b>
<b>Certification</b>	<b>BS EN 10204:2004 Type 2.2</b>
<b>Material safety data sheet</b>	<b>MSDS 05</b>
<b>Re-dry</b>	<b>2 Hours @ 250<sup>o</sup>C if required</b>
<b>Related Nexus Products</b>	<b>MIG Nexus 308LSi TIG Nexus 308L</b>