

## SATINCROME 308L-17

45  
OCVAC  
DC+

- ▲ Ultra-Seal vacuum packs.
- ▲ 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.

## Classifications:

AS/NZS 1553.3: (old)	E308L-17.
AS/NZS 4854: (new)	B E308L-17
AWS/ASME-SFA A5.4:	E308L-17.

## 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

## APPROVALS:

American Bureau of Shipping AWS 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	75J av @ +20°C.

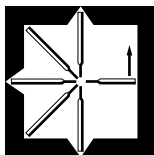
## TYPICAL ALL WELD METAL ANALYSIS:

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

## FERRITE NUMBER:

3.0 - 10.0 FN\*

\* - using Severn Gauge



All positional - except  
vertical down

## Packaging and Operating Data:

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

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	47	40-70	2.5kg	15kg - 6 x 2.5kg	611602
3.2	350	28	75-110	2.5kg	15kg - 6 x 2.5kg	611603
4.0	350	18	110-150	2.5kg	15kg - 6 x 2.5kg	611604