

ARCALOY 308L-17 PLUS

AWS A5.4: E308-17/E308L-17

FEATURES

Arcaloy 308L-17 Plus electrodes have a heavy coating, produce a concave bead with minimum ripple and the slag is virtually self-cleaning. These electrodes are designed to weld Types 304, 304L, 321 and 347 for corrosion service at temperature up to about 600°F(315°C). The excellent wetting action and very fine ripple minimize crevice corrosion and grinding time. This is particularly useful in the food and drink industry where a smooth polished surface is required.

TYPICAL MECHANICAL PROPERTIES

Yield Stress	58 ksi, 400 MPa
Tensile Strength	86 ksi, 550 - 600 MPa
Elongation in 2"	47%

CLASSIFICATIONS AND APPROVALS

- AWS A5.4: E308-17/E308L-17
- ASME IX F No. 5
- ASME II SFA A5.4: E308-17/E308L-17
- CWB:CSA W48 E308L-17

WELDING PROCESS

- SMAW (Stick)

WELD METAL ANALYSIS

C	0.02%
Mn	0.6%
Si	0.8%
Cr	19%
Ni	10%
Mo	0.1%
Cu	0.1%
Ferrite	6 FN

INDUSTRIES

- Rail Road Car
- General Fabrication
- Food and Beverage
- Shipbuilding

ARCALOY 308L-17 PLUS continued

WELDING PARAMETERS

Diameter in (mm)	Flat Amps	Vertical Amps	Overhead Amps
1/16 (1.6)	20 - 35	15 - 25	20 - 30
5/64 (2.0)	30 - 50	25 - 35	30 - 40
3/32 (2.4)	60 - 85	40 - 60	40 - 60
1/8 (3.2)	90-120	70-80	60 - 85
5/32 (4.0)	140-165	80-90	95 - 120
3/16 (4.8)	180-210	100 - 115	125 - 150
1/4 (6.4)	205 - 290		

PART NUMBER / PRODUCT INFORMATION

Part Number	Description	UPC
251035358	AC 308L-17 3/32X12X8#HS	662303028527
251035366	AC 308L-17 1/8X14X10#HS	662303028534
251035374	AC 308L-17 5/32X14X10#HS	662303028541
251035382	AC 308L-17 3/16X14X10#HS	662303028558