



Quality Management System
In accordance with
ISO 9001
Cert # 05-R0925

308L-15 Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
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American Welding Society
Sustaining Company Member



ALLOY DESCRIPTION AND APPLICATION;

308L electrodes contain extra low carbon for the welding of austenitic, low carbon 18% Cr – 8% Ni stainless steels such as AISI-304-ELC. The weld deposit of this electrode contains a maximum of 0.04% carbon, which greatly reduces the formation of chromium carbides, thereby protecting the corrosion resistant qualities of the base metal and weld. 308L electrodes have a high deposition rate resulting in excellent efficiency. This electrode may be used in all positions. In addition to 304-ELC, 308L electrodes may be used for stabilized stainless steels such as AISI 321 and 347, joint welds in construction parts for chemical engineering and cryogenic applications. The -15 coating will help for vertical down welding but found very good in vertical up.

TYPICAL WELDING PROCEDURES; DCEP

Diameter	Amps	Diameter	Amps
1/16"	20-40	1/8"	80-110
5/64"	35-50	5/32"	105-145
3/32"	55-75	3/16"	165-200

Arc Length = short arc, Flat use 15° angle from 90°, Vertical up & Overhead use weaving techniques within puddle

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.
When welding vertical reduce amperage 10-20%

TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Carbon	0.030		
Manganese	0.93	Phosphorus	0.018
Silicon	0.59	Sulfur	0.015
Chromium	19.68	Nickel	10.15
	Elongation		45%
	Yield Strength (psi)		64,000
	Tensile Strength (psi)		89,000

Iron balance and all single values are maximum percentages

AVAILABLE SIZES: TF308L-15 = 3/32", 1/8", 5/32", 5/32"

SPECIFICATIONS; ANSI/AWS A5.4 E308L-15
ASME SFA 5.4 E308L-15

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