

#### DESCRIPTION

Executive stainless steel coated electrodes are a superior operating SMAW filler metal that can be used in a variety of applications. Executive 308/308L is dual certified for both low carbon and standard carbon grades reducing duplication of inventories. Best suited for general purpose welding as the flux coating provides a smooth arc transfer in all positions except vertical down.

Executive 308/308L is a versatile electrode designed to weld several types of austenitic steels with low carbon levels to help eliminate carbide precipitation in high temperature service.

#### APPLICATIONS & FEATURES

Ideal for welding types 302, 304 and 308 stainless steels, as well as A743 and A744 Type CF-8 cast material.

#### TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cr	Ni
0.02	0.60	1.10	0.03	0.010	19.0	9.6

<b>Tensile Strength:</b>	76,800 PSI min	<b>Elongation:</b>	45%	<b>Ferrite Range:</b>	5-9 FN (WRC-92)
<b>Yield Strength:</b>	56,000 PSI min				

#### TYPICAL WELDING PARAMETERS

Process	Diameter	Length	Amperage
<b>SMAW</b>	3/32"	12"	40-70
<b>AC/DC</b>	1/8"	14"	60-100
	5/32"	14"	90-140
	3/16"	14"	120-185

#### STANDARD PACKAGING & HANDLING

<b>SMAW</b>	40-lb master box
	10-lb plastic tube

Executive Stainless electrodes should be stored in their unopened and undamaged original packaging at 18-25°C with 60% max relative humidity. Electrodes slightly affected by moisture may be re-baked for approx. three hours at 250-280°C. Both heating and cooling should be carried out gradually.

The consequences of moisture pick-up are not as serious for stainless steel electrodes as they are for Executive mild steel electrodes.

#### CLASSIFICATION

AWS/SFA 5.4, Class **E308/308L-16**

