

LKE-308-16



LINKWELD ALLOYS INC.

AWS	A5.4 E308-16
EN	EN1600 E 19 9 R 1 2
JIS	Z3221 D308-16

Characteristics:

The weld metal of LKE-308 is a rutile electrode (19%Cr-10%Ni). It is suitable for the welding of AISI Types 304,301and 302 in all positions.

Applications:

It is suitable for welding of stainless steel piping in refinery, oil and gas industries, and chemical plants.

Notes on Usage:

- 1.Dry the electrodes at 200-250°C for 60 minutes and keep at 100-150°C before use.
- 2.To make the cooling time as short as possible between 500-800°C to prevent the intergranular corrosion.
- 3.Clean up the slag with stainless steel brush to prevent impurity.
- 4.Use small heat input to reduce dilution, prevent cracking and improve impact value.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ni
0.06	1.30	0.35	0.014	0.008	19.38	9.90

Typical mechanical properties of weld metal

TS N/mm ²	EL %
570	47

Welding position:



Sizes and recommended current range (AC or DC <+>)

Diameter (mm)		2.0	2.6	3.2	4.0	5.0
Length (mm)		250	300	350	350	350
Amps	F	30-55	50-85	80-120	100-150	140-180
	V&OH	20-50	45-80	70-110	90-135	-
Weight per pack(kg)		4/5	4/5	5	5	5
Weight per carton (kg)		20	20	20	20	20