



LKE-308L-16

LINKWELD ALLOYS INC.

AWS A5.4 E308L-16
 EN EN1600 E 19 9 L R 1 2
 JIS Z3221 D308L-16

Characteristics:

The weld metal of LKE-308L is a rutile electrode for welding low carbon 18Cr-8Ni stainless steel. LKE-308L contains low carbon to avoid carbide precipitation during welding.

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
0.03	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