

SHUBER E 608L

STAINLESS STEEL ELECTRODE



DESCRIPTION

STAINLESS STEEL ELECTRODE WITH A RUTILE COVERING FOR ARCHITECTURAL USE AND GENERAL CORROSION RESISTANCE. EXTRA LOW CARBON IN THE WELD DEPOSIT ENSURES AGAINST HARMFUL INTERGRANULAR CORROSION. Highly suited for welding stainless steels corresponding to AISI 304L, 304, 308L and 308 used in the fabrication and repair of equipment used in the dairy, food processing, drug and chemical industries; as padding between layers of hardsurfacing materials.

SPECIAL FEATURES

- Extra-low carbon prevent carbide precipitation.
- Deposition rate & efficiency higher than most brands in its class.
- Excellent weldability particularly in vertical & overhead welding.

APPLICATION INSTRUCTIONS

Deposit stringer beads with as short an arc as possible. Avoid weaving to prevent slag inclusions. Use skip or stepback technique to avoid overheating and warpage. Remove slag between each pass.

TYPICAL WELD METAL ANALYSIS:

C	Cr	Mn	Ni	Si
0.03(max)	19.0	0.80	10.0	0.7

TENSILE STRENGTH: 60kg/mm² (85,000 psi)

ELONGATION: 48%

RECOMMENDED CURRENT:

AC or DC +(Reverse Polarity)

DIAMETER	AMPS
2.4 mm (3/32")	55 - 85
3.2 mm (1/8")	70 - 110
4.0 mm (5/32")	110 - 150

Tip Colour: Blue

DIN 8556:
E 19 9 nC R 23