

308L/MVR-16

For welding steels such as Outokumpu	EN	ASTM	BS	NF	SS
4301	1.4301	304	304S31	Z7 CN 18-09	2333
4307	1.4307	304L	304S11	Z3 CN 18-10	2352
4311	1.4311	304LN	304S61	Z3 CN 18-10 Az	2371
4541	1.4541	321	321S31	Z6 CNT 18-10	2337

Standard designations

EN 1600	E 19 9 L R
AWS A5.4	E308L-16

Characteristics

AVESTA 308L/MVR-16 is a Cr-Ni electrode for all position welding of ASTM 304 and 304L stainless steel.

Welding data

DC+ or AC	Diam., mm	Current, A
	2.5	60 – 80
	3.25	80 – 100
	4.0	110 – 140

Typical analysis % (All weld metal)

C	Si	Mn	Cr	Ni
0.02	0.6	0.6	19.3	10.0

Ferrite 10 FN DeLong

Mechanical Properties

	Typical values (IIV)	Min. values EN 1600
Yield strength $R_{p0,2}$	470 N/mm ²	320N/mm ²
Tensile strength R_m	570 N/mm ²	510 N/mm ²
Elongation A_5	37 %	30 %
Impact strength KV		
+20°C	60 J	
-40°C	55 J	
Hardness, approx.	200 Brinell	

Interpass temperature: Max. 150°C.

Heat input: Max. 2.0 kJ/mm.

Heat treatment: Generally none. In special cases quench annealing at 1050°C.

Structure: Austenite with 5 – 10 % ferrite.

Scaling temperature: Approx. 850°C (air).

Corrosion resistance: Very good under fairly severe conditions, e.g. in oxidising acids and cold or dilute reducing acids.

Approvals

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Welding positions

