



308LMo

For welding steels such as Outokumpu	EN	ASTM	BS	NF	SS
General purpose electrode, recommended for welding ASTM CF3M stainless steel castings and wrought materials such as type 316L stainless to achieve a higher ferrite content than what is attainable with 316 electrodes.					

Standard designations

AWS A5.4 E308LMo-17

Characteristics

AVESTA 308LMo is a general purpose electrode for welding dissimilar joints and repair and maintenance. The weld metal exhibits excellent tolerance to dilution from dissimilar and difficult-to-weld steels. 308LMo can also be used for welding type 316L stainless steel, when an increased ferrite content is desired.

Welding data

DC+ or AC	Diam., mm	Current, A
	2.50	45 – 70
	3.25	60 – 110
	4.0	90 – 150

Weld deposit data

Metal recovery approx. 105 %.

Typical analysis % (All weld metal)

C	Si	Mn	Cr	Ni	Mo
0.02	0.8	0.7	19.7	9.9	2.5

Ferrite 20 FN WRC-92

Mechanical Properties

	Typical values (IIV)	Min. values AWS A5.4
Yield strength $R_{p0.2}$	560 N/mm ²	–
Tensile strength R_m	700 N/mm ²	520 N/mm ²
Elongation A_5	35 %	35 %
Impact strength KV +20°C	62 J	

Interpass temperature: Max 150°C.

Heat input: Max. 2.0 kJ/mm.

Heat treatment: Generally none.

Structure: Austenite with 18–22 % ferrite.

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

Corrosion resistance: Good resistance to general corrosion.

Approvals

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Welding positions

