

HABCO 308L-16 (S)

MICRO-DENSE COATED SPRAY TRANSFER SUPER STAINLESS ELECTRODE

FEATURES

The **HABCO 308L** stainless steel electrodes are balanced chemistry electrodes that have superior welding characteristics. They are designed with a special, spray type arc transfer that results in less heat input because of the closer arc gap that can be maintained while welding. This also makes them easier to use in all positions. The arc stabilizer used in the coating make them outstanding when used on AC, particularly with limited duty cycle, low open circuit voltage AC machines. They have greatly improved crack resistance, even on demanding applications, and also have good corrosion resistance. The slag is virtually self-lifting. The special HABCO coating insures dense, porosity free deposits. They not only retard moisture pick-up, but will automatically readjust the moisture content to a safe level once it is brought back to a drier atmosphere, without the need of re-baking.

APPLICATIONS

For fabricating and repair of types 201, 202, 204, 301, 304 and 308 stainless steel. These electrodes are used where service conditions are not severe. Generally used on large fabricated parts involving high volumes of welding, dairy and restaurant equipment and chemical tanks; also for CF-8, CF-3, CF20 and HF castings.

INSTRUCTIONS

Clean weld area of foreign material. A 60° bevel is used when welding parts 3/16" or heavier. DC reverse polarity is preferred. Use lowest amp setting possible to get good bead contour, which is usually about 20% less than for mild steel. In fabricating, tack weld at close intervals using next smallest diameter electrode. Chip slag and stainless steel wire brush tacks before welding. Use stringer beads where possible and keep close arc gap while welding. Avoid excess heat build-up. Thin sheets may have to be clamped with chill blocks to avoid excessive distortion.

Tensile Strength: up to 90,000 Psi (63 kg/mm²)

Yield Strength: up to 64,000 Psi (45 kg/mm²)

Elongation in 2": 45 %

Corrosion Resistance: Good

Current: AC or DC +

Amperage	40-80	60-120	90-150	140-220
Diameters: (in)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0

- Available in TIG and WIRE form
- Certified by CWB to CSA STANDARD W48
- Conforms to AWS A5.9 E309L-16