böhler welding by voestalpine

Lasting Connections

BÖHLER Q E 308L-17

High alloyed stick electrode for welding of austenitic stainless steel like 1.4301 or 1.4306 or AISI 304L

Main benefit

Core wire alloyed stick electrode for very homogeneous corrosion resistance.

Product features	Product benefits	User benefits
» **Core wire alloyed coating concept**	» Homogeneous chemistry of every single stick from the beginning up to the end	» Homogeneous weld seams lead to reliable corrosion resistance
» **Designed for easy welding**	» Minimum spatter formation » Self-releasing slag	» Less post weld cleaning » Lower total welding time
» **Rutile coated**	» Easy to handle » Very good welding characteristics	» Fine ripped weld seams » Shiny surface for visible seams
» **Designed for high quality welds**	» Very good mechanical properties	» Welding for high demanding industries

Typical applications

- Chemical industry
- Food and beverage industry
- Storage tanks
- Stainless steel parts for buildings

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Classifications			Operating data	
EN ISO 3581-A	AWS A5.4 / SFA-5.4		Welding positions	Polarity
E 19 9 L R 3 2	E308L-17			

Typical analysis of all weld metal, wt. %					
	C	Si	Mn	Cr	Ni
	0.03	0.80	0.80	19.80	10.2

Mechanical properties, all weld metal (single values typical)						
	Condition	Yield strength $R_{p0.2\%}$ MPa	Tensile strength R_m MPa	Elongation A ($L_0 = 5d_0$) %	CVN Impact toughness ISO-V KV J 20 °C	–120 °C
	As welded	430 (≥ 320)	560 (≥ 520)	40 (≥ 30)	70	≥ 32

Steels to be welded	
EN	ASTM
1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2CrNiN18-10, 1.4312 G-X10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10	AISI 304, 304L, 304LN, 302, 321, 347; UNS S30400, S30403, S30453, S32100, S34700 ASTM A157 Gr. C9, A320 Gr. B8C or D

Approvals
TÜV (10647), ABS, DNV, CE

Packaging - Standard size		Carton Packaging - PocketBox	
	Weight: Standard box ~ 4,1 kg Diameter 2.5 x 300 mm 3.2 x 350 mm 4.0 x 350 mm		Weight: 1.0 kg Diameter 2.5 x 300 mm 3.2 x 350 mm 4.0 x 350 mm