

GEMINI 308 L

Typical Applications And Characteristics

GEMINI 308L is a general purpose, extra low carbon, austenitic electrode with rutile coating for welding corrosion-resistant CrNi steels. Resistant to atmospheric and resistant to grain disintegration of operating temperatures up to 350 °C. Very smooth weld with clean weld edge. Low spatter loss and easy slag removal. For welding AISI 302,304,304L,304LN

Typical All-Weld Metal Properties

Composition (%)		Mechanical	
C	0.01	Yield strength	482 N/mm ²
Mn	0.60	Tensile strength	590 N/mm ²
Si	0.60	Elongation	46 %
Ni	10.00		
Cr	19.30		

Typical welding current

AC or DC+/-					
Ø/L (mm)	2.0/300	2.6/300	3.2/350	4.0/350	5.0/350
Current min/max (A)	30/50	50/75	75/110	110/150	140/190

International Standard	Printing	Welding Positions
AWS/ASME SF-A5.4 E308L-16	G-308L/E308L-16	Flat, horizontal, vertical-up and overhead