

GEMINI 308 L

AWS/SFA5.4 E 308L-16

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 stress	520 N/mm ²
Mn	0.70	Tensile strength	590 N/mm ²
Si	0.60	Elongation	40 %
Ni	10.00		
Cr	19.30		

AC or DC±					
∅/L (mm)	2.0X300	2.6X300	3.2X350	4.0X350	5.0X350
Current min/max (A)	30-50	50-75	75-110	110-150	140-190

Typical welding current			
Approval	Color	End	Yellow
LR TIS. 730-2530	Coding	Side	Blue
	Printing	G-308L/E 308L-16	
	Welding Positions	Flat, horizontal, vertical-up and overhead	