



# Cromarod B308L

SMAW - (Stick) - MMA  
Stainless Steel

Date: 2020-12-01  
Revision: 7

### Description:

Basic coated stainless steel electrode for type 304L/304LN steel grades. Produces weld metal with higher toughness at lower temperatures compared to rutile coated electrodes. The basic coating results in higher resistance to porosity due to improved gas shield, making the electrode highly suitable for on site welding. Cromarod B308L has an easy slag removal even in narrow joint preparations, reducing post-weld cleaning time.

### Applications:

Offshore, pipeline, restrained joints.

### Welding positions:



### Coating type:

Basic

### Welding current:

DC+

### Ferrite content:

FN 5 (WRC 92)

### Metal recovery:

110%

### Redrying temperature:

350 °C, 2h

### Chemical composition, wt. %

	C	Si	Mn	P	S	Cr	Ni
Min			0,8			18,0	9,0
Typical	0,03	0,35	1,0	0,02	0,01	19,0	10,0
Max	0,04	0,50	1,2	0,030	0,025	21,0	11,0

	Mo	Cu
Min		
Typical	0,03	0,1
Max	0,5	0,5

### Mechanical properties

	Specified	Typical
Yield strength, Rp0.2%:	≥ 320 MPa	450 MPa
Tensile Strength, Rm:	≥ 520 MPa	570 MPa
Elongation, A5	≥ 30%	40%
Impact energy, CV:		-50 °C • 70 J -196 °C • 45 J lat exp 0.6 mm

### Product data:

Diam.mm	Length mm	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	300	50-80	24	0,69	86	0,83	43
3,2	350	75-125	25	0,69	43	1,24	59
4,0	350	100-165	26	0,69	28	1,94	60

### Classification:

AWS A5.4 E308L-15  
ISO 3581-A E 19 9 L B 42

### Approvals:

CE

### Note

For fixed pipe position PF/5G, electrode diameter 3,25 mm is the max recommended size.

Core wire:  
P ≤ 0.020%  
S ≤ 0.015%  
N ≤ 0.080%

\*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and ELGA AB expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the corresponding EN ISO specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by ELGA AB.