

TECH-ROD 308

- I. **DESCRIPTION:** Tech-Rod 308 electrodes are used to weld unstabilized 18-8 stainless steels such as Types 301, 302, 304, 305, and 308. Tech-Rod 308 electrodes provide corrosion resistance and physical properties equal to or greater than the steels for which they are recommended. Typical applications include dairy, distillery and restaurant equipment, and chemical tanks.
- II. **APPROVALS:** Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.4 Class E308-16.

III. **CHEMICAL COMPOSITION**

Carbon	.05
Manganese	1.65
Silicon	.52
Chromium	23.5
Nickel	12.3
Sulfur	.02
Phosphorus	.021
Nitrogen	.05
Iron	Balance

MECHANICAL PROPERTIES

Tensile Strength	
84,500 PSI	580 MPA
Yield Strength	
55,000 PSI	380 MPA
Elongation	40%

IV. **WELDING PARAMETERS**

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

V. **PACKAGES AVAILABLE:**

3/16"-10# can, 5/32"-10# can, 1/8"-10# Can, 3/32"-8# can