



MANGALAM®

S.S. Electrodes- F 308L

Versatile And Reliable Stainless Steel Electrode

MANGALAM E 308L is a rutile-type, extra low-carbon electrode designed for welding AISI 304L, 308L, 321, and 347 stainless steels. This electrode ensures excellent ductility, crack resistance, and oxidation resistance. It is highly suitable for applications in industries requiring strong, reliable welds in challenging environments.

Engineered For Versatility And Performance



Welding Cr-Ni Steels Such As
AISI 301, 302, 304, And 308.



Stainless Steel Components In The Food
And Chemical Industries.



Pipeline Welding In Oil And
Refinery Plants



Fabrication Of Boilers, Reactors,
And Turbines.

Packing Data

SWG Size	Size (Mm)	Electrodes/Packet	Electrodes/Carton	Current (Amps)
12	2.50 x 350	2 Kg	10 Kg / 5 Pkt	45 - 85
10	3.15 x 350	2 Kg	10 Kg / 5 Pkt	15 - 115
8	4.00 x 350	2 Kg	10 Kg / 5 Pkt	100 - 140
6	5.00 x 350	2 Kg	10 Kg / 5 Pkt	140 - 180

Chemical Composition Of Weld Metal (%)

Element	Composition (%)
Carbon (C)	0.04 max
Manganese (Mn)	0.50 - 2.50
Silicon (Si)	1.00 max
Sulphur (S)	0.030 Max
Phosphorus (P)	0.040 Max
Nickel (Ni)	9.00 - 11.00
Chromium (Cr)	18.00 - 21.00
Molybdenum (Mo)	0.75 Max

Mechanical Properties Of All Weld Metal

Property	Value
UTS (N/mm²)	520 Min
Elongation (%)	30 Min
Ferrite No.	3 - 7

Test Performance:

Radiography Test Blue Standard - *Satisfactory*

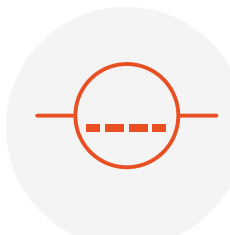
Storage Stability - *Satisfactory*



Current Conditions



Operates on **AC** current.



Operates on **DC** current.

Welding Positions: F, H, V-UP, OH.

