AWS Spec. Alloys: Stainless Steel, A5.4

E308L-16 A low-carbon stainless-steel electrode with a nominal composition of 20% Cr and 10% Ni. Characterized by a smooth arc with easy slag removal, this electrode is most often used for welding base metal of similar composition - such as AISI types 301, 302, 304 and 305. Use AC and DCEP. Store dry and sealed or in a rod oven.

Code #	Size	Type & Specification	Amperage	Tensile	Yield	Elongation
120-4-0308 120-5-0308	1/8" 3/32"	CLASS E308L-15 & 16 MIL-E-22200/2 MIL-308L-15 & 16	65-100 40-70	95,000 psi 655 MPa	30,000 psi 207 MPa	45%

E309L-16 This stainless steel electrode (nominal composition 23.5% Cr, 13% Ni) is commonly used for joining type 304 to carbon-steel or welding similar alloys in wrought or cast form. The low-carbon content improves the intergranular corrosion resistance. This electrode is characterized by a smooth-arc, flat fillet weld profile with easy slag removal. Use on AC or DCEP. Store dry and sealed or in a rod oven.

Code #	Size	Type & Specification	Amperage	Tensile	Yield	Elongation
120-4-0309 120-5-0309	1/8" 3/32"	AWS A5.4, ASME SFA 5.4 CLASS E309L-15	65-100 40-70	85,000 psi 586 MPa	30,000 psi 207 MPa	40%

E316L-16 This electrode deposits a nominal composition of 18.5% Cr, 12.5% Ni and 2.5% Mo and is commonly used for welding stainless steel of the AISI Type 316 or 316L. The low-carbon content improves the corrosion resistance, and the addition of Molybdenum improves pitting resistance and increases resistance to high temperatures (1600˚F - 870˚C). Characterized by a smooth arc, low spatter and low operating amperage, the E316L type is excellent for many stainless steel applications. Use AC or DCEP.

Code #	Size	Type & Specification	Amperage	Tensile	Yield	Elongation
120-3-0316	5/32"	AWS A5.4, ASME SFA 5.4	100-145	90,000 psi	40,000 psi	40%
120-4-0316 120-5-0316	1/8" 3/32"	CLASS E316L-15 & 16 MIL-E-22200/2, 65-100 MIL-316L-15 & 16	65-100 40-70	621 MPa	276 MPa	

AWS Spec. Alloys: Low Alloy Steel, A5.5

E11018-M A high-strength low-alloy (HSLA) low-hydrogen electrode that was developed for welding T-1 steels in all applications. It has a very high yield strength which makes it ideal for heavy equipment. Excellent for padding or buildup prior to hardfacing. Preheat is often required when welding on HSLA steels. Use AC or DCEP.

Code #	Size	Type & Specification	Amperage	Tensile	Yield	Elongation
120-2-0110 120-3-0110 120-4-0110 120-5-0110	3/16" 5/32" 1/8" 3/32	AWS A5.5 ASME SFA5.5 MIL-11018-M MIL-E-0022200/1, ABS AWS 5.5	160-230 120-170 90-140 60-85	110,000 psi 758 MPa	100,000 psi 689 MPa	21%