

308/308L Sterling® AP



AWS A5.4: E308-16 & 308L-16

WELDING POSITIONS:



FEATURES:

- Spray-like arc transfer
- Directional arc
- Easy strike and re-strike
- All-position
- Self-detaching slag

BENEFITS:

- Low spatter and less clean-up
- Metal goes where directed
- Easy to use, less chance of starting defects
- Welds extremely well in flat, horizontal, vertical (up) and overhead positions
- Less chance of slag inclusions

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP) or AC

RECOMMENDED WELDING PROCEDURES:

- ARC LENGTH:** Short (less than 1/2 the diameter of the electrode)
- FLAT & HORIZONTAL:** Angle electrode 10-15° from 90°
- VERTICAL-UP:** Use weaving techniques or inverted V. Reduced amperage compared to flat position setting
- VERTICAL-DOWN:** Not recommended
- OVERHEAD:** Use slight weaving motion within the puddle

STORAGE: Sterling AP® electrodes have a high degree of moisture resistance; however, for critical applications, the electrodes should be held at 215°F - 300°F after opening.

RECONDITIONING: If exposed to atmosphere for extended periods, recondition at 660°F for 2 hours.

TYPICAL WELD METAL PROPERTIES* (Chem Pad):

Weld Metal Analysis (%)		AWS Spec	
		E308-16	E308L-16
Carbon (C)	0.02	0.08 max	0.04 max
Manganese (Mn)	0.70	0.5 to 2.5	0.5 to 2.5
Phosphorus (P)	0.02	0.04 max	0.04 max
Sulphur (S)	0.02	0.03 max	0.03 max
Silicon (Si)	0.70	0.90 max	0.90 max
Copper (Cu)	0.10	0.75 max	0.75 max
Chromium (Cr)	19.5	18.0 to 21.0	18.0 to 21.0
Nickel (Ni)	10.00	9.0 to 11.0	9.0 to 11.0
Molybdenum (Mo)	0.10	0.75 max	0.75 max

TYPICAL MECHANICAL PROPERTIES* (As Welded):

Mechanical Tests		AWS Spec	
		E308-16	E308L-16
Tensile Strength	84,800 psi (585 MPa)	80,000 psi	80,000 psi
Yield Strength	66,000 psi (455 MPa)	Not required	Not required
Elongation % in 2" (50 mm)	42%	35%	35%
DeLong Ferrite Number Range	4-12	Not required	Not required
Schaeffler Number Range	4-12	Not required	Not required
WRC Number Range (1992)	4-12	Not required	Not required

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the AWS A5.4 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 Hobart Brothers Company.

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Diameter		Weld Positions	Type of Current	Amperage Range	
Inches	(mm)			Min.	Max.
3/32	(2.5)	Flat & Horizontal	DCEP or AC	60	80
1/8	(3.2)	Flat & Horizontal	DCEP or AC	80	100
5/32	(4.0)	Flat & Horizontal	DCEP or AC	100	140
3/16	(5.0)	Flat & Horizontal	DCEP or AC	140	220

- Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.

AVAILABLE DIAMETERS AND PACKAGES:

Diameter		Length		5-Lb. Can	6-Lb. Can	7-Lb. Can
Inches	(mm)	Inches	(mm)			
3/32	(2.5)	12	(300)	S481931-036	—	—
1/8	(3.2)	14	(350)	—	S481944-032	—
5/32	(4.0)	14	(350)	—	S481951-032	—
3/16	(5.0)	14	(350)	—	—	S481958-039

CONFORMANCES AND APPROVALS:

- AWS A5.4, Class E308-16 & E308L-16
- ASME SFA 5.4
- CWB

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

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