

# PRIMALLOY® JS-308/308L

## TYPICAL APPLICATIONS

- Designed for the welding of common "18-8" austenitic stainless steels, such as type 302, 304, 304L & CF-8.
- Petrol Chemical Equipment Manufacturing.
- Power Generation Construction.
- Food & Beverage Equipment.
- Shipbuilding & Offshore.
- Transportation Equipment Manufacturing.

## TOP FEATURES

- Rutile-Basic stainless steel electrode.
- Weldable on AC and DCEP polarity.
- Excellent weldability in all position welding except vertical down.
- High resistance to weld porosity.
- Easy slag removal.
- PRIMALLOY® JS-308L can produce lower carbon content weld metal with higher resistance to intergranular corrosion.

## CONFORMANCE

- AWS A5.4/A5.4M E308-16
- AWS A5.4/A5.4M E308L-16

## WELDING POSITIONS



## APPROVAL

- PRIMALLOY® JS-308: CCS
- PRIMALLOY® JS-308L: ABS

## DIAMETERS / PACKAGING

Diameter x Length(mm x mm)	Weight /Packet (KG)	Weight / Carton (KG)
2.5 x 300	2	20
3.2 x 350	5	20
4.0 x 350	5	20
5.0 x 350	5	20

## MECHANICAL PROPERTIES

Electrode		Yield Strength (MPa)	Elongation (%)	Ferrite Number (FN)
PRIMALLOY® JS-308	AWS Requirement	≥550	≥35	--
	Typical Value	620	39	7
PRIMALLOY® JS-308L	AWS Requirement	≥520	≥35	--
	Typical Value	610	40	8

## CHEMICAL COMPOSITION

		C%	Si%	Mn%	P%	S%	Cr%	Mo%	Ni%	Cu%
PRIMALLOY® JS-308	AWS requirements	≤0.08	≤1.0	0.5-2.5	≤0.04	≤0.03	18.0-21.0	≤0.75	9.0-11.0	≤0.75
	Typical values	0.04	0.83	0.88	0.022	0.012	20.63	0.12	9.37	0.012

# PRIMALLOY® JS-308/308L

## CHEMICAL COMPOSITION

		C%	Si%	Mn%	P%	S%	Cr%	Mo%	Ni%	Cu%
PRIMALLOY® JS-308L	AWS requirements	≤0.08	≤1.0	0.5-2.5	≤0.04	≤0.03	18.0-21.0	≤0.75	9.0-11.0	≤0.75
	Typical values	0.024	0.84	0.81	0.014	0.011	20.47	0.10	9.55	0.017

## TYPICAL OPERATING PROCEDURES

Diameter x Length (mm x mm)	Welding Polarity	2.5*300	3.2 x 350	4.0 x 350	5.0 x 350
Current [A]	1G,2G,2F	50-85	80-120	100-150	140-180
Current [A]	3G up,4G	45-80	70-110	90-140	--

### Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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The product performance data of this brochure and related attachments are from LINCOLN ELECTRIC application engineering laboratory. Except for special instructions, experiments on welding machines are conducted in accordance with the general standard of IEC60974-1; experiments on welding consumables are conducted in accordance with the general standard of AWS; for specific applicable standards on welding consumables please refer to the product page. The product performance data of this website and related attachments are from LINCOLN ELECTRIC American application engineering laboratory.

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