

# S-308Mo.16

TYPE : Rutile

AWS A5.4 / ASME SFA5.4 E308Mo-16  
JIS Z3221 ES308Mo-16  
EN 1600 - E 20 10 3

SWAW

## Applications

All positional lime-titania type electrode which is extremely suitable for welding molybdenum containing austenite stainless steel.

S-308Mo.16 can be used for welding such type as 316 stainless steel when increased ferrite is desired beyond that attainable with S-316.16N electrode.

## Characteristics on Usage

This electrode welds smoothly with low spatter and good slag detachability.

## Notes on Usage

- ① Dry the electrodes at 350°C(662°F) for 60 minutes before use.
- ② Keep the arc as short as possible, and avoid large width of weaving.
- ③ Dirt such as oil and dust should be completely removed from groove.

## Welding Position



1G 2F 3G 4G  
(PA) (PB) (PF) (PE)

## Current

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.03	0.65	0.77	0.032	0.017	18.5	9.7	2.3

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)
621 (90,200)	42.3

## Approval

## I Packing

Packet 2.5 kg (5.5 lbs)  
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)
Length mm(in)	300 (12)	300 (12)	350 (14)	350 (14)
F	50~85	70~140	95~145	135~180
V-up, OH	45~80	65~110	85~135	-