



## 308LMo

For welding steels such as  
Outokumpu

EN

ASTM

BS

NF

SS

General purpose electrode, recommended for welding ASTM CF3M stainless steel castings and wrought materials such as type 316L stainless to achieve a higher ferrite content than what is attainable with 316 electrodes.

**Standard designations**

AWS A5.4 E308LMo-17

**Characteristics**

AVESTA 308LMo is a general purpose electrode for welding dissimilar joints and repair and maintenance. The weld metal exhibits excellent tolerance to dilution from dissimilar and difficult-to-weld steels. 308LMo can also be used for welding type 316L stainless steel, when an increased ferrite content is desired.

**Welding data**

DC+ or AC	Diam., mm	Current, A
	2.50	45 – 70
	3.25	60 – 110
	4.0	90 – 150

**Weld deposit data**

Metal recovery approx. 105 %.

**Typical analysis % (All weld metal)**

C	Si	Mn	Cr	Ni	Mo
0.02	0.8	0.7	19.7	9.9	2.5

Ferrite 20 FN WRC-92

**Mechanical Properties**

	Typical values (IIV)	Min. values AWS A5.4
Yield strength $R_{p0.2}$	560 N/mm <sup>2</sup>	–
Tensile strength $R_m$	700 N/mm <sup>2</sup>	520 N/mm <sup>2</sup>
Elongation $A_5$	35 %	35 %
Impact strength KV +20°C	62 J	

**Interpass temperature:** Max 150°C.**Heat input:** Max. 2.0 kJ/mm.**Heat treatment:** Generally none.**Structure:** Austenite with 18–22 % ferrite.**Scaling temperature:** Approx. 850°C (air).**Corrosion resistance:** Good resistance to general corrosion.**Approvals**

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**Welding positions**