



308L DC Lime

AWS E308L-15

Replaces 020520

170-B, INDEX: 060127

DESCRIPTION:

Featuring a fully alloyed core wire that contains extra low carbon to prevent carbide precipitation, **308L DC Lime** is excellent for use with Type 308 base metals with low or medium carbon content, as well as 18 Cr-8 Ni steels. It has convex bead and is an excellent choice when welding highly restrained joints or for crack sensitive materials. Ideal for pipe welding and cryogenic applications.

Note: Actual certs are included in every master carton of stainless stick electrodes at no charge.

Features	Benefits
<ul style="list-style-type: none"> • Globular transfer • Electrode doesn't overheat • Easy strike and re-strike • All-position 	<ul style="list-style-type: none"> • Low spatter and less clean-up • Less stub loss, cost-effective • Easy to use, less chance of starting defects • Welds extremely well in flat, horizontal, vertical (up) and overhead positions
<ul style="list-style-type: none"> • Extremely high moisture resistance • Low oxygen and nitrogen 	<ul style="list-style-type: none"> • Extends shelf life of product in open environment • Excellent for low temperature (-320°F) impact properties

TYPICAL WELD METAL PROPERTIES* (CHEM PAD):

Weld Metal Analysis		AWS Spec
Carbon (C)	0.03	0.04 max
Manganese (Mn)	1.14	0.5 to 2.5
Phosphorus (P)	0.012	0.04 max
Sulphur (S)	0.013	0.03 max
Silicon (Si)	0.43	0.90 max
Copper (Cu)	0.10	0.75 max
Chromium (Cr)	19.68	18.0 to 21.0
Nickel (Ni)	9.89	9.0 to 11.0
Molybdenum (Mo)	0.10	0.75 max

TYPICAL MECHANICAL PROPERTIES* (AS WELDED):

		AWS Spec
Tensile Strength	83,000 psi (573 MPa)	80,000 psi
Yield Strength	64,000 psi (442 MPa)	not required
Elongation % in 2"	37%	35%
DeLong Ferrite Number Range	4-10	not required
Schaeffler Number Range	4-10	not required
WRC Number Range (1992)	4-10	not required

Note: Nitrogen (N) assumed to be 0.06% for calculation purposes.

CONFORMANCES AND APPROVALS:

- AWS Spec A5.4, Class E308L-15 • ASME SFA5.4

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



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RECOMMENDED WELDING PROCEDURES:

- GENERAL:** DCEP (electrode positive, work negative) or AC
- ARC LENGTH:** Short (less than half the diameter of the electrode)
- FLAT & HORIZONTAL:** Angle electrode 10-15° from 90°
- VERTICAL-UP:** Use weaving techniques. Reduced amperage compared to flat position setting
- OVERHEAD:** Use slight weaving motion within the puddle
- STORAGE:** DC Lime electrodes have a high degree of moisture resistance; however, for critical applications, the electrodes should be held at 225° F after opening.
- RECONDITIONING:** If exposed to atmosphere for extended periods, recondition at 500° F for 1 hour

RECOMMENDED OPERATING PARAMETERS:

Diameter		Type of Power	FLAT & HORIZONTAL		
Inches	mm		Minimum Amps	Optimum Amps	Maximum Amps
3/32	2.4	DCEP or AC	45	65	80
1/8	3.2	DCEP or AC	55	105	120
5/32	4.0	DCEP or AC	65	140	170
3/16	4.8	DCEP or AC	160	170	205

AVAILABLE DIAMETERS AND PACKAGES:

Diameter		Length		6-lb. Can	10-lb. Can
Inches	mm	Inches	mm		
3/32	2.4	10	254	S472530-032	—
1/8	3.2	14	355	—	S472544-033
5/32	4.0	14	355	—	S472551-033
3/16	4.8	14	355	—	S472558-033

Material Safety Data Sheets on any McKay product may be obtained from McKay Customer Service.

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