

Characteristics and Applications:

The weld metal of HOBART TS-308L is a 19Cr-10Ni austenite microstructure containing limited δ ferrite. The product has excellent slag detachability, weld bead appearance, weldability, corrosion resistibility at high temperature. It is suitable for the welding of AISI-304 steel, AISI-301 steel and AISI-302 steel in all positions. Suitable for welding of stainless thin plate, hoop, pipe, seamless pipe, thermal pipe, pressure vessel plate, steel bar, forge.

Notes on Usage:

1. Clean up the contaminations on the base metal groove and pass to pass with stainless steel brush.
2. Maintain short arc length. Moving range should be controlled within 2.5 times of the wire's dia when you are welding with weave method.
3. Dry the electrodes at 250~300°C for 60 minutes before using. Take out consumables for half day consumption and keep in the environment at 100~150°C during welding process.
4. Use lower current to prevent from cracking and minimize base metal dilution.

Typical Chemical Composition of Weld Metal (wt%)

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
AWS	≤0.04	0.5-2.5	≤1.00	≤0.04	≤0.03	9.0-11.0	18.0-21.0	≤0.75	≤0.75
EN ISO	≤0.04	0.5-2.5	≤1.00	≤0.04	≤0.03	9.0-12.0	18.0-21.0	≤0.75	≤0.75
Typical value	0.022	0.85	0.62	0.03	0.010	9.6	18.8	0.07	0.10

Typical Mechanical Properties of Weld Metal

	Tensile strength MPa(ksi)	Elongation %
AWS	≥520(75)	≥30
EN ISO	≥520(75)	≥25
Typical value	580(84)	45

Welding Position



Sizes and Recommended Operating Range (AC or DC+)

Sizing Chart						
Diameter (mm)		2.0	2.6	3.2	4.0	4.8
Length (mm)		250	300	350	350	350
Current (Amps)	F	40-60	60-90	80-130	130-170	160-200
	V&OH	30-50	50-80	70-110	100-130	-