

Limarosta 304L

Key Features

- All positional Electrode (except vertical down) suitable for welding 304 stainless steel.
- Excellent wetting characteristics.
- High resistance to porosity.

Typical Applications

- Suitable for root pass.
- Stainless steel pipe and structural applications.

Conformances

AWS A5.4: E308L-17
AS/NZS 4854-A: E 19 9 L R 22

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	557329-1	CB 2.0 kg (6 x CB per carton)
3.2	350	557367-1	CB 4.2 kg (3 x CB per carton)

Mechanical Properties

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ +20°C
Requirements - AWS	-	520 min	30 min	-
Requirements - AS/NZS	320 min	510 min	30 min	-
Typical Results - As Welded	440	600	≥35	75

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.03	0.8	1.00	0.025	0.01
	%Ni	%Cr	FN (acc.WRC 1992)		
Typical Results - As Welded	10.0	19.5	5-10		

Typical Operation Procedures

Polarity	Current (amps)	
	2.5mm	3.2mm
DC+	70-90	100-120