

# Ultramet™ B308LCF

## TOP FEATURES

- Basic pipe-welding electrode for cryogenic 304L applications
- High moisture resistance
- Particularly suited to the most demanding vertical and overhead welding applications
- Recovery is about 110%

## TYPICAL APPLICATIONS

- LNG

## CLASSIFICATION

AWS A5.4 E308L-15  
EN ISO 3581-A E 19 9 L B 4 2

## CURRENT TYPE

DC+

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

ABS	TÜV
+	+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	not specified	0.5	not specified	not specified	not specified	18.0	9.0	not specified	not specified	2
Max.	0.04	2.0	0.90	0.025	0.030	21.0	11.0	0.50	0.5	5
Typical	0.03	1.2	0.3	0.01	0.015	18.5	10	0.05	<0.1	3

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded	Min.	Typical
Tensile strength	(MPa) 520	600
0.2% Proof strength	(MPa) 320	440
Elongation (%)	4d 35	44
	5d 30	40
Reduction of area (%)	not specified	60
Impact ISO-V (J)	+20 °C not specified	80-120
	-196 °C not specified	35-50
Lateral expansion* (mm)	-196 °C 0.38	0.55

\*Batch tested for Charpy lateral expansion >0.38mm at –196 °C.

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	50-70
3.2 x 350	65-100
4.0 x 350	80-140

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	106	1.8	UMB308LCF-25-2
3.2 x 350	VPMD	60	2.0	UMB308LCF-32-2
4.0 x 350	VPMD	40	2.0	UMB308LCF-40-2

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.