

Avesta 308L/MVR-4D

Basic stick electrode high-alloyed, chemical resistant

Classifications

EN ISO 3581-A	AWS A5.4

E 199LR

E308L-17

Characteristics and typical fields of application

Avesta 308L/MVR-4D is a thin-coated, rutile-acid type electrode specially developed for welding thin-walled pipes and sheets in 1.4301/304 type steels. The electrode is characterised by its good weldability in different positions and the good restriking properties. Avesta 308L/MVR-4D is primarily intended for pipe and position welding, but can also be used as a general purpose electrode, especially for thin material.

Corrosion resistance:

Very good under fairly severe conditions, e.g. in oxidising acids and cold or dilute reducing acids.

Base materials								
Outokumpu	EN	ASTM	BS	NF	SS			
4301	1.4301	304	304S31	Z7 CN 18-09	2333			
4307	1.4307	304L	304S11	Z3 CN 18-10	2352			
4311	1.4311	304LN	304S61	Z3 CN 18-10 Az	2371			
4541	1.4541	321	321S31	Z6 CNT 18-10	2337			
Typical analysis of all-weld metal (wt%)								
	С	Si	Mn	Cr	Ni			
wt-%	0.02	0.8	0.6	19.2	9.7			

Mechanical properties of all-weld metal

ment $R_e N/mm^2$ $R_m N/mm^2$ $(L_0=5d_0)$		
MPa MPa %	+20 °C -40	°C HB
u 440 560 35	55 40	210

u untreated, as-welded

Operating data

	Polarity: DC(+)	Electrode identification:	ø (mm) 1.6 2.0 2.5 3.25	L mm	Amps A 15 – 40 25 – 55 30 – 85 45 – 110
Approvals					

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