

### DESCRIPTION

Executive PLUS electrodes have a unique European formulation designed for the most discriminating operator. Improved silica-titania (AC-DC) coating resists moisture pick up. A careful selection of raw materials and an advanced manufacturing process guarantees the electrodes resist starting porosity; even under extreme humidity and when left exposed to the atmosphere for prolonged periods. Noble chemistry improves corrosion resistance in challenging environments and actual weld deposit chemistries as well as controlled ferrites with each batch.

Executive PLUS 308/308L are a superior operating SMAW filler metal that can be used in a variety of applications. They are dual certified for both low carbon and standard carbon grades reducing duplication of inventories. Executive PLUS 308/308L is a versatile electrode designed to weld several types of austenitic steels with low carbon levels to help eliminate carbide precipitation in high temperature service.

### APPLICATIONS & FEATURES

Best suited for general purpose welding as the flux coating provides a smooth arc transfer in all positions except vertical down. Ideal for welding types 302, 304 and 308 stainless steels, as well as A743 and A744 Type CF-8 cast material.

Executive PLUS features include: high current-carrying capacity, a smooth finely rippled weld bead, self-detaching slag with no residue, elimination of starting porosity, superior arc stability with excellent strike and restrike characteristics.

### TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

| C      | Cr   | Ni  | Mn  | Si   |
|--------|------|-----|-----|------|
| <0.025 | 19.5 | 9.5 | 0.8 | <0.9 |

|                          |                           |                        |                |                    |     |
|--------------------------|---------------------------|------------------------|----------------|--------------------|-----|
| <b>Tensile Strength:</b> | 83,000 PSI min            | <b>Yield Strength:</b> | 50,000 PSI min | <b>Elongation:</b> | 40% |
| <b>Charpy V-Notch:</b>   | 48 ft/lb at -76°F / -60°C |                        |                |                    |     |

### TYPICAL WELDING PARAMETERS

| Process | Diameter | Length | Amperage |
|---------|----------|--------|----------|
| SMAW    | 3/32"    | 14"    | 40-70    |
| AC/DC   | 1/8"     | 14"    | 60-100   |
|         | 5/32"    | 14"    | 90-140   |
|         | 3/16"    | 14"    | 120-185  |

### STANDARD PACKAGING & HANDLING

|      |       |                  |                    |
|------|-------|------------------|--------------------|
| SMAW | .093" | 9-lb metal can   | 27-lb master box   |
|      | .125" | 9-lb metal can   | 27-lb master box   |
|      | .156" | 9.5-lb metal can | 28.5-lb master box |
|      | .187" | 9.5-lb metal can | 28.5-lb master box |

### CLASSIFICATION

AWS/SFA 5.4, Class **E308/308L-17**  
Certified by the Canadian Welding Bureau (CWB) to AWS A5.4

