

Suggested weld data about: **Base Metal: Stainless Steel****Process: SMAW****Position: All Position****Current/Polarity: DCRP (DCEP)****Electrode Type: Lime, basic coating, good penetration electrode****Note:**

Electrode -15 produce globular mode, produce cleanest weld metal and convex profile that is best "hot cracking resistance" and penetration preferred for narrow grooves and other than flat. Parameters are based on manufacturers' recommendation survey.

Smaller size electrode applicable for root passes or on thinner metal**Always choose electrode size less than the thickness****Filler Metal Electrodes:****AWS A5.4:** E308L-15, E316L-15, E308-15, E316-15 or similar stainless steel electrodes (E3XX)

Electrode Size in. (mm)	A	Position
5/64 (2.0 mm)	30-50	Flat/Horizontal
3/32 (2.4 mm)	40-70	Flat/Horizontal
1/8 (3.20 mm)	65-100	Flat/Horizontal
5/32 (4.0 mm)	100-145	Flat/Horizontal
3/16 (4.8 mm)	130-190	Flat/Horizontal

Electrode Size in. (mm)	A	Position
5/64 (2.0 mm)	30-50	Vertical