

ER308L

AWS A5.9 ER308L
EN ISO 14343-A : G 19 9 L

Description:

A super low carbon Stainless welding wire used to weld Types 201, 302, 304 and 308 stainless steels, Can also be used for joining some dissimilar 300 series steels. The low carbon content to help prevent intergranular corrosion. Used to weld super low carbon 18%Cr8%Ni or similar stainless steels, like ASTM 304L, 304LN, 308L base metal etc.

Welding Position:



Diameters:

0.8mm,0.9mm,1.0mm,1.2mm.

Typical Mechanical Properties:

Tensile strength(MPa):	630
Yield strength(MPa):	455
Elongation(%):	38

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.020	1.95	0.012	0.008	0.50	10.1	20.0	0.011	0.015

Welding Current:(DC+)

Diameter(mm)	0,8	0,9	1,0	1,2
Current/A	55-160	65-220	80-240	100-300
Voltage/V	15-24	15-28	15-28	15-29

Note:

- 1.Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
- 2.Shield Gas:Ar+0,5-5%CO₂ or Ar+0,5-3%O₂.
- 3.Gas speed:20-25L/Min
- 4.DC+ connection; Arc length:4-6mm.

5. Tig rods ER308L 1.6mm, 2.0mm, 2.4mm, 3.2mm available