Technical data sheet 011121MBA	Cored welding wire # TRI S 308L-O	Welding Alloys

CLASSIFICATION

EN ISO 17633-A:	T 19 9 L U NO 3
ASME IIC SFA 5.22 / AWS A 5.22:	E308LT0-3
EN ISO 17633-B:	TS308L-F NO 0
Equivalent Material number:	1.4316
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Special flux cored self-shielded stainless steel wire for open arc welding
- 19% chromium - 9% nickel - low carbon deposit
- The weld beads produced have a self-releasing slag covering which leaves a clean surface
- Sound deposits are obtained even in the presence of cross draughts
- Primary choice for cladding and rebuilding application
- Suited for joining
- Provides maximum productivity for outdoor jobs

APPLICATIONS

The TRI S series of wires is designed for on-site weld surfacing, repair and assembly of stainless steels. Good quality welds may be obtained, even when they are used in difficult weather conditions.
TRI S 308L-O is suitable for welding and cladding stainless steels with alloy content between 16 to 21% Cr and 8 to 13% Ni stabilised or not.

Examples:

AISI	UNS	Material number	EN Symbol
302	S30200	1.4300	X12 CrNi 18 8
304	S30400	1.4301	X5 CrNi 18-10
304L	S30403	1.4306	X2 CrNi 19-11
304LN	S30453	1.4311	X2 CrNiN 18-10
305	J92701	1.4312	GX10 CrNi 18-8
308	S30800	1.4303	X4 CrNi 18-12
321	S32100	1.4541	X6 CrNiTi 18-10
347	S34700	1.4550	X6 CrNiNb 18-10

APPROVALS

TÜV (02215.02)

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	S	P
0.02	1.80	0.80	20.5	10.0	0.008	0.020

Typical ferrite level: 8 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
520	320	35	+ 20°C: 40

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
690	490	40	- 60°C: 60

SHIELDING GAS

None

OPERATING CONDITIONS

Current type	Gas flow rate	Stick out	Recovery
DC+	-	25 - 45 mm	88 %

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	1.2 mm	1.6 mm	2.0 mm	2.4 mm
Spool type	EN ISO 544: BS300			
Weight	15 kg			

Other packaging and other diameters: please consult us