Technical data sheet 011121MBA	Stainless steel - Solid wire # WA TSS 308L	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.9 / AWS A 5.9:	ER308L
EN ISO 14343-A:	W 19 9 L
UNS Number:	S30883
Equivalent Material number:	1.4316
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Solid GTAW rod for welding austenitic Cr-Ni-Mo stainless steels
- 19% chromium - 9% nickel - low carbon deposit

APPLICATIONS

WA TSS 308L is suitable for welding stainless steels with an 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

TYPICAL WIRE ANALYSIS (% by weight)

C	Mn	Si	Cr	Ni	Mo
0.010	1.60	0.50	20	10	0.1

All-weld metal typical ferrite level: 5 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
510	320	30	-196°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
600	420	35	- 196°C: 60

SHIELDING GAS

EN ISO 14175: I1: Pure argon. Gas flow rate: 7-10 l/min

OPERATING CONDITIONS

Wire diameter	1.6 mm	2.4 mm	3.2 mm
Minimum current intensity [A]	50	60	70
Maximum current intensity [A]	100	120	130

DCEN

WELDING POSITIONS

All positions

PACKAGING

Diameter	1.6 mm / 2.4 mm / 3.2 mm
Length	1000 mm
TUBE	5 kg

Other packaging and other diameters: please consult us