

GETIG 308L



IDENTIFICATION : ER 308L

SPECIFICATIONS :AWS /SFA 5.9 ER 308L;DIN 8556-86 WSGX2 CrNi199;BS 2901-90 308S92

DESCRIPTION:

Extra low carbon Austenitic Stainless Steel Filler Rod.

CHARACTERISTICS :

An extra low carbon 20/10 filler rod which has excellent resistance to intergranular corrosion due to its extra low carbon content. The weld deposit is corrosion and scale resistant and free from porosity. The deposited weld metal meets X-ray/ radiographic quality. Good resistance to oxidizing acids and reducing adds.

APPLICATIONS :

For welding of 19/10 austentic stainless steel plates of the type AISI 301,302,304,304 L, sheets, pipes and tubes used in chemical plants,fertilizer plants, oil refineries, food and dairy industries. Can be used for welding stablised stainless steel 347 &321 provided service temperatures for structural application are below 4000C. Also used for making furniture, hospital and kitchen equipments etc.

Sizes(MM) : 1.2, 1.6, 2.0, 2.5 and 3.15 mm

Shielding Gas : GAS Argon, 99.99%, 6-12 l/min

Packing Specifications : Supplied in cut lengths of 1 meter packed in 5 kgs cartons)

COMPOSITION OF THE WIRE (RANGE) %:

C	Mn	Si	S	P	Cr	Cu	Mo	Ni
0.025 max	1.0-2.5	0.30-0.65	0.020 max	0.030 max	19.5-22	0.50 max	0.5 max	9.0-11.0

ALL WELDMECHANICAL PROPERTIES:

Tensile Strength	Yield Stress (mpa)	Elongation (%) (L=4D)	Charpy V-notch impact strength	
			Temp	Joules
520 min	430 min	35 min	20°C	80-140
			-196°C	30-60

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	Recommended Current (Amps) DC (-)	LENGTH (mm)	Kg per carton / pkt
1.6	100-200	1000	5.00
2.0	150-250	1000	5.00
2.5	200-300	1000	5.00
3.20	300-400	1000	5.00