

GM 308L



IDENTIFICATION :ER 308L

CLASSIFICATION :AWS/SFA 5.9 ER308L BS 2901-90 308 S92 DIN 8556-86 WSGX2 CrNi199

CHARACTERISTICS :

A solid, smooth wire primarily intended for welding the low carbon, 18%Cr,10%Ni, type 304 , austenitic stainless steels. Deposited weld metal has improved resistance to general corrosion .The deposited weld metal is of radiographic quality.

TYPICAL APPLICATIONS:

Suitable for welding normal carbon 304, 304L grades and Nb or Ti stabilized steels type 347 and 321 provided service temperatures are below 400°C. Widely used for chemical process plants.

WELD METAL ANALYSIS (RANGE) %:

C	Mn	Si	Cr	Ni	Cu	Mo	S	P
0.030 max	1.0-2.5	0.30-0.65	19.50-21.0	9.0-11.0	0.50 max	0.50max	0.025 max	0.030 max

MECHANICAL PROPERTIES (RANGE) :

Tensile Strength MPa	Yield Stress MPa	Elongation(%) (L=4D)	Charpy V-notch impact strength (joules)
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530-650	360-480	35-45	Temp	Joules
			20°C	100-140
			-100°C	40-80

CORROSION RESISTANCE:

Good resistance to general and intergranular corrosion oxidizing acids. Good resistance to chlorise pitting corrosion.

FERRITE : Ferrite no. of undiluted weld metal is in the range 3 to 10

WELDING CURRENT : DC (-)

SHIELDING GAS : Ar + 2 % O₂, 16-21 l/min

PACKING DATA :

SIZE (mm)	Wt.of the spool (Dia.of spool : 300mm layer to layer winding)KG (approx)
0.80	12.50
1.00	12.50
1.20	12.50
1.60	12.50