

SA 308L

CATEGORY SAW Arc Submerged

TYPE Solid stainless steel wire for submerged arc welding (SAW)

APPLICATIONS Boilers, agriculture, liquid storage tanks, food machinery, furniture etc.

PROPERTIES 308L has good general corrosion resistance. The alloy has a low carbon content, making it particularly recommended where there is a risk of intergranular corrosion.
Best to be used with our agglomerated flux [FL 8111](#)

CLASSIFICATION

AWS	A 5.9: ER 308L
EN ISO	14343-A: S 19 9 L
DIN: W.Nr.	1.4316

SUITABLE FOR

W.Nr: 1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4546, 1.4312, 1.4300, 1.4312, 1.4371, 1.4541, 1.4543, 1.4550, 1.4452
 DIN X2CrNi 19 11 (TP), X4CrNi 18 10 (TP), X6CrNiTi 18 10 (TP), X6CrNiNb 18 10 (TP), X2CrNi 18 10 (TP), X5CrNiNb 18 10, G-X10CrNi 18 8 (TP),
 AISI 202, 302, 304L, 304, 305, 321, 347, 304 LN
 ASTM A320 Grade B8C/D, 302

APPROVALS CE approved

WELDING POSITIONS:



CAST ANALYSIS

C	Mn	Si	Cr	Ni	Mo
<0.03	1,7	0,4	18-20	9-10	<0,30

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				+20°C	-40°C	-196°C	
AW	>350	570	35	~120		>50	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,6			K-300 / K-415	15 / 25	
2,0			K-415	25	
2,4			K-415	25	
3,2			K-415	25	
4,0			K-415	25	

REDRYING TEMPERATURE not required