

CLASSIFICATIONS

EN ISO 14343-A : W 19 9 L

AWS A5.9 : ER 308 L

DESCRIPTION

- TIG welding of 13% Cr ferritic stainless steels, high-carbon steels of type 304, or stabilized steels of type 347, or steels of similar qualities, all of which used in drug, cellulose, paper and food (production) industries
- The shielding gas is Argon (Ar).
- Maintenance of ductile behavior at temperature values down to -196°C
- Maintenance of resistance against intergranular corrosion at temperatures up to 400°C

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.02 | Si:0.5 | Mn: 1.7 | Ni: 9.8 | Cr: 20.1

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/+20°C)	Elongation (L _o =5d _o) (%)
min. 390	540 - 660	min. 63 J	min. 35

BASE MATERIALS

- X2CrNi 19 11, X5CrNi 18 10, X6CrNiTi 18 10, X6CrNiNb 18 10, X2CrNiN 18 10, X10CrNiNb 18 10
- AISI & ASTM: 304, 304L, 304LN, 347, 321, A320Gr.B8C, A320Gr.B8D

WELDING POSITIONS



CURRENT CONDITION

TIG D.C.(-)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100021	1.6 x 1000	1/16 x 39"	5	Plastic Box
1011100022	2.0 x 1000	5/64 x 39"	5	Plastic Box
1011100023	2.4 x 1000	3/32 x 39"	5	Plastic Box
1011100024	3.2 x 1000	1/8 x 39"	5	Plastic Box