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308L Data Sheet

DESCRIPTION: Alloy 308L has the same analysis as type 308 except that the carbon content has been held to a maximum of .03% to reduce the possibility of inter-granular carbide precipitation. It is ideal for welding types 304L, 321, and 347 stainless steels. This is a suitable wire for applications at cryogenic temperatures.

APPROVALS: Manufactured under Quality System approved by ASME, IS09001. Meets AWS A5.9 Class ER308L.

CHEMICAL COMPOSITION
Carbon 0.030
Manganese 1.000-2.500
Silicon 0.300-0.650
Chromium 19.500-21.000
Nickel 9.000-11.000
Molybdenum 0.300
Sulfur 0.020
Phosphorus 0.030
Copper 0.300

MECHANICAL PROPERTIES
Tensile Strength
85,000 PSI (590 MPA)
Yield Strength
57,000 PSI (390 MPA)
Elongation 40%

WELDING PARAMETERS
MIG WELDING: Direct current; Electrode +Ve
Shielding Gas:
98/99% Argon + 2/1% Oxygen
97% Argon + 3% CO2
Gas Flow: 30 to 50 CFH
Voltage: 29 to 33
Amperage:
160/180 for .035" (0.9mm)
180/220 for .045" (1.14mm)
210/250 for .062" (1.6mm)

TIG WELDING: Direct Current; Electrode –Ve
Shielding Gas: 100% Argon
Gas Flow: 30 to 40 CFH