

Filler rod and wire

Features:	▪ Suitable for low carbon 18%Cr-8%Ni steel
Classification:	AWS A5.9 ER308L
Shielding gas:	Ar
Identification color:	1st Red
Polarity:	DCEN

Packaging data

ϕ mm	Spool		Tube		
	kg	kg	Length mm	g/piece	
0.8	10	5	1,000	4	
1.0	10	5	1,000	6	
1.2	10	5	1,000	9	
1.6	10	5	1,000	16	
2.0	-	5	1,000	25	
2.4	-	5	1,000	36	
3.2	-	5	1,000	64	
Volume mm	240W, 110H, 240L		40W, 35H, 1015L		

Composition (rod and wire mass%)

	Typical	Guaranty ^a
C	0.01	0.03
Si	0.37	0.30~0.65
Mn	1.8	1.0~2.5
P	0.02	0.03
S	<0.01	0.03
Ni	10.1	9.0~11.0
Cr	19.8	19.5~22.0
Mo	0.07	0.75
Cu	0.08	0.75

Note: ^a Single values are maximum.

Welding parameters

ϕ mm	Current A
0.8	50~80
1.0	50~80
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250
3.2	200~300

All-weld mechanical properties

	Typical
0.2%YS (MPa)	420
TS (MPa)	590
El on 4d (%)	45
IV -196°C (J)	78

Approvals

ABS	AWS A5.9 ER308L
LR	MG
DNV	NV308L, MG
BV	308LBT, UP
NK	KY308L
GL	4306
CCS	AS1-A