

SUNMIG 308L

Low Carbon Austenitic Stainless Steel Solid Welding Wire



CLASSIFICATION

AWS A 5.9 : ER308L

CHARACTERISTICS

SUNMIG 308L is austenitic Stainless steel welding wire, the weld metal contains ferrite and resistance to crack is extremely good. Low carbon assists austenitic arc stability and improves corrosion resistance such as intergranular type. It gives radiographic quality welds.

APPLICATIONS

SUNMIG 308L welding wire of low carbon 19%Cr-9%Ni steel for Automobiles and Chemical Industries such as Oil, Medical, Fertilizer, Textile and Railway Industries and for Nuclear reactors. It is designed for welding SS 301, 302, 304, 304L, 308, 308L, 321 and 3447 grades.

SPECIFIED CHEMICAL COMPOSITION OF BARE SOLID WIRE (%):

C	Mn	Si	Cr	Ni	Mo	S	P
0.03 max	1.0-1.25	0.30-0.65	19.5-22.0	9.0-11.0	0.75 max	0.03 max	0.03 max

SPECIFIED MECHANICAL PROPERTIES OF ALL WELD METAL:

Ultimate Tensile Strength (N/mm ²)	Elongation % (GL=4d)
521.0 min	35.0 min

Mechanical properties will vary with the type of shielding gas used.

PACKING DATA:

Diameter (mm)	KG/spool
0.8	12.5 Kg
1.2	12.5 Kg
1.6	12.5 Kg
2	12.5 Kg

SHIELDING GAS : 98% Argon –Balance O₂ or 95-99% Argon –Balance O₂

GAS FLOW : 15-22 L/min

CURRENT : DCEN