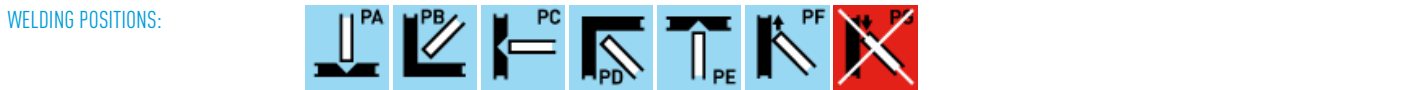


CATEGORY	GMAW-GTAW Solid wires
TYPE	Stainless steel GMAW filler metal for welding CrNi 18/10 types.
APPLICATIONS	Boilers, tanks, agriculture, liquid storage tanks, food machinery, furniture.
PROPERTIES	CEWELD® 308L has good general corrosion resistance. The alloy has a low carbon content, making it particularly recommended where there is a risk of intergranular corrosion.

CLASSIFICATION	AWS	A 5.9: ER308L
	EN ISO	14343-A: W 19 9 L
	F-nr	6
	FM	5
	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), X2CrNiN 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
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TYPICAL WELD DEPOSIT WEIGHT %					
C	Si	Mn	Cr	Ni	
0.02	0.5	2	20	10	

ALL WELD MECHANICAL PROPERTIES						
Heat Treatment	R <sub>p0,2</sub>	R <sub>m</sub>	A <sub>5</sub>	RT	Impact Energy (J) ISO-V	
As Welded /	MPa	MPa	(%)		-60°C	-196°C
	480	630	37	170	150	75

WELDING PARAMETERS / PACKING					
WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A) DC+	SPOOL TYPE	KG SPOOL	KG / PALLET
0.6	-	-	D-200 / D-300	5 / 15	1000 / 1080
0.8	12-24	55-160	D-200 / S-300 / DRUM	5 / 15 / 250	1000 / 1080 / 1000
1.0	15-28	80-240	D-200 / S-300 / DRUM	5 / 15 / 250	1000 / 1080 / 1000
1.2	15-29	100-300	S-300 / DRUM	15 / 250	1080 / 1000
1.6	23-31	150-375	S-300 / DRUM	15 / 250	1080 / 1000

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175	M11, M13, M12
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