

TIGWELD 308 L-LF

TIG Rods [GTAW]

Stainless and high alloyed steels

CLASSIFICATION: EN ISO 14343-A : W 19 9 L DIN 8556 : SG X1 CrNi 19 9 AWS A-5.9 : ER 308 L W.Nr. : ~1.4316	APPROVALS:	APPLICATION: Power generation industry Petrochemical and chemical industry
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- Wire for welding similar stainless steels, resistant to corrosion.
- Used in all branches of industry where homogeneous steel grades and 13% chromium ferritic steels are welded up to a temperature of 350°C.
- Suitable for cryogenic applications down to -169°C.
- Low ferrite content FN: 3-7.
- Recommended where there is a high risk of intergranular corrosion.
- Can be used for chromium steels in environments with limited sulfur concentrations.

Application

Tanks and chemical equipment, chemical and pharmaceutical, cellulose and food industries.



Base material

AISI/ASTM	DIN	W.Nr.
304	X5CrNi 18 9	1.4301
304L	X2CrNi 18 9	1.4306
347	X10CrNiNb 18 9	1.4550
304LN	X2CrNiN 18 10	1.4311
	GX10CrNi 18 8	1.4312
A193Grade B8T	X6CrNiTi 18 10	1.4541
	X5CrNiNb 18 10	1.4546

Typical chemical composition %

C	Si	Mn	Cr	Ni	N
0,01	0,40	1,90	19,80	10,90	0,07

Typical mechanical properties

Yield strength Re [N/mm²]	>320
Tensile strength Rm [N/mm²]	>510
Elongation A5 [%]	>25
Impact energy Kv [J]	>80J (20°C) / >32J (-196°C) /
Wire/rod type	solid
Ferrite content	FN: 3 - 7
Welding current	
Welding positions	

Shielding gases acc. to EN ISO 14175

I1 - Ar / I3 - Ar + >0-95% He /

Welding parameters and packing

∅	Length [mm]	Weight of packet [kg]
1,0	1000 /	5,0
1,2	1000 /	5,0
1,6	1000 /	5,0
2,0	1000 /	5,0
2,4	1000 /	5,0
3,0	1000 /	5,0

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