

# TI 308L

TIG Welding Wire - Stainless Steels

### Standards

AWS/ASME SFA - 5.9	ER308L
EN ISO 14343 - A	W 19 9 L
TS EN ISO 14343 - A	W 19 9 L
DIN M. No.	1.4316

### Properties and Applications

Austenitic stainless steel welding rod for GTA (TIG) welding of unstabilized or stabilized corrosion resisting Cr-Ni steels. Used in tank, pipe, equipment welding in food, beverage, chemical and pharmaceutical industries. Resistant to intergranular corrosion up to 350°C. Non-scaling up to 800°C, in air or oxidizing combustion gases.

### Materials

Width	Material	ASTM
X5CrNi18-10	1.4301	304
X4CrNi18-12	1.4303	305
X2CrNi19-11	1.4306	304L
X2CrNi18-10	1.4311	304LN
X6CrNiTi18-10	1.4541	321
X6CrNiNb18-10	1.4550	347, 347H
GX5CrNiNb19-11	1.4552	

### Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni
Welding Wire	0.02	0.45	1.80	19.75	10.50

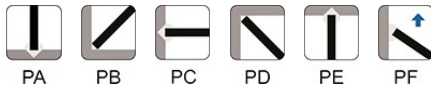
### Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	I1	460	620	39	20°C → 195	-196°C → 50

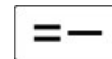
\* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

### Application Information

#### Welding Positions



#### Polarity:



Protection Gas:  
I1

#### Welding Parameters & Efficiency

Diameter x Length (mm)
1.20x1000
1.60x1000
2.00x1000
2.40x1000
3.20x1000

### Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
23102EBKM2	1.20x1000	5 kg	5.30	4	21.40	Cardboard Tube
23102GBKM2	1.60x1000	5 kg	5.30	4	21.40	Cardboard Tube
23102HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
23102IBKM2	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube
23102IGKM2	2.40x1000	5 kg	5.30	4	21.40	
23102LBKM2	3.20x1000	5 kg	5.30	4	21.40	Cardboard Tube

### Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.