

Exaton 308/308L

308/308L is used for MIG/MAG welding, and is suitable for joining stainless steels of the 18Cr/8Ni/ELC and 18Cr/8Ni/Nb types for service temperatures up to 350°C (660 F). 308/308L is approved by TÜV-Rheinland for use at cryogenic temperatures down to 4°K (-269°C).

Classifications Wire Electrode	SFA/AWS A5.9 : ER308L EN ISO 14343-A : G 19 9 L Werkstoffnummer : 1.4316
Approvals	CE EN 13479 DB 43.039.01 VdTUV 01339

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C
Shielding Gas	M12, M13 (EN ISO 14175)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.011	1.9	0.3	0.008	0.018	10.1	19.6	0.3	0.15	0.06

Typical Weld Metal Analysis %

Nb	Ti	Co	FN WRC-92
0.01	0.003	0.05	6

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.010	1.8	0.4	0.009	0.020	10.8	19.8	0.2	0.2	0.05

Typical Wire Composition %

Nb	Ti	Co	FN WRC-92
0.01	0.003	0.10	6

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm (0.030 in.)	40-120 A	15-19 V	4.0-8.0 m/min (157-315 in./min)
1.0 mm (0.040 in.)	60-220 A	15-28 V	4.0-12.0 m/min (157-472 in./min)
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)
1.6 mm (1/16 in.)	230-350 A	25-30 V	3.0-5.0 m/min (118-197 in./min)