

DATA SHEET N. 3051

DAIKO 308L

TIG - SAW

Description / Alloy type: Solid wire 308L austenitic stainless steels for 304L base materials.

Specifications: **AWS A5.9** **EN ISO 14343-A** **EN ISO 14343-B**
ER308L 19 9 L SS308L

Applications: These consumables are used to weld 18/8 stainless steels.
Mainly applications include food industries, pharmaceutical equipment and general fabrication.
Typical service temperatures are -100°C to 400°C.

Composition:
(weight %)

%	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min	-	1.0	0.30	-	-	19.5	9	2.0	-	3
Max	0.025	2.0	0.65	0.020	0.030	21.0	11	3.0	0.3	12
Typ	0.010	1.7	0.40	0.010	0.015	20	10	2.6	0.15	10

Typical parameters:

	TIG	SAW
Shielding	Argon	Daikoflux 300T
Current	DC-	DC+
Diameter	2.4 mm	2.4 mm
Parameters	100A, 12V	350A, 28V

All-weld properties:

As welded	Typ. TIG	Typ. SAW
Tensile strength [MPa]	605	570
Yield strength [MPa]	465	450
Elongation on 5d [%]	33	37
Impact Energy -130°C [J]	>100	50

Complementary products: GMAW wire (AWS A5.9 ER308LSi)
SMAW electrodes (AWS A5.4 E308L-17 / E308L-16 / E308L-15)
FCAW wire (AWS A5.22 E309LMoT0-1/4 / E309LMoT1-1/4)