

**DATA SHEET N. S10 - 001**

# DAIKOWT 308L

**TIG**

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

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

Approvals: TÜV (TIG); CE.

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.

Materials to be welded: **ASTM:** 304L; 304; 304LN; CF3; CF8; 321; 347.  
**UNS:** S30403; S30400; S30453; S32100; S34700.  
**EN & DIN:** 1.4306; 1.4301; 1.4311; 1.4308; 1.4541; 1.4543/1.4561  
1.4550.

Composition:  
(weight %)

%	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
<b>Min</b>	-	1.0	0.30	-	-	19.5	9	-	-	3
<b>Max</b>	0.025	2.0	0.65	0.020	0.030	21.0	11	0.3	0.3	12
<b>Typ</b>	0.010	1.7	0.40	0.010	0.015	20	10	0.1	0.15	10

Typical parameters:

	<b>TIG</b>
Shielding	Argon
Current	DC-
Diameter	2.4 mm
Parameters	100A, 12V

All-weld properties:

As welded	<b>TIG</b>
Tensile strength [MPa]	600
Yield strength [MPa]	460
Elongation [%]	35
Impact Energy -130°C [J]	>80
Impact Energy -196°C [J]	>70

Other products: MIG and TIG wire (AWS A5.9 ER308LSi)  
SMAW electrodes (AWS A5.4 E308L-16 / E308L-15 / E308L-17)  
FCAW wire (AWS A5.22 E308LT0-1/4 / E308LT1-1/4)

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