



TIG 308L



Standards

AWS 5.9

ER 308L

EN ISO 14343-A

W 199 L

W. Nr.

1.4316

Description & applications

Filler material in solid wire sticks for TIG welding of Molybdenum-free austenitic stainless steels type 304, 304L, 321, 347. Used for standard applications and moderate corrosion environments, for systems service conditions not exceeding 350°C.

Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Mo	S max	P max	Fe
0.025	1.8	0.45	20.5	10.0	-	0.02	0.02	Base

Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV -196°C
600 MPα	400 MPα	40 %	48 J

Operating parameters

Shielding gas recommendations :

EN ISO 14175 II : 100 % Argon 6-12 l/mn Root: Argon, Nitrogen : 3-6 l/mn



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SADEV INOX – 2 Allée des Faisans – 74600 SEYNOD – France

Tel: 04 50 33 70 75/ Fax 04 50 33 70 38 info@sadevinox.com www.sadevinox.com