Etrichstraße 19-21 A-2542 KOTTINGBRUNN Austria.

MIG AND TIG STAINLESS STEEL WIRES.

Swiss Alloys® 308/308L

SPECIFICATIONS
AWS 5.9
ASME SFA 5.9
EN ISO 14343 EN steel no. 19 9 L

CLASSIFICATIONS
AWS ER308/308L
UNS S30883

DESCRIPTION / APPLICATION

Swiss Alloys ER308L is ideal for welding Types 304L, 321, and 347. This classification is the same as Swiss Alloys ER308, except for the carbon content. The carbon content is held to a maximum of .03% to reduce the possibility of intergranular carbide precipitation. This in- creases the resistance to intergranular corrosion without the use of stabilizers such as columbium (niobium) or titanium. Strength of this low-carbon alloy, however, is less than that of the columbium (niobium)-stabilized alloys or Type 308H at elevated temperatures.

Typical Chemical Analysis						
C	**Mn**	**Si**	**Cr**	**Ni**	**S**	**P**
0.03 max	1.0-2.5	0.30-0.65	19.5-22.0	9.0-11.0	0.03 max	0.03 max
Mo	**Cu**					
0.75 max	0.75 max					

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 85,000 psi 590 MPa
Yield strength: 57,000 psi 390 MPa
Elongation: 40%

Approvals CE, DB, TÜV

Typical Welding Parameters of Stainless steel wire			
Process	Diameter of Wire	Welding Voltage (V)	Welding Current (A)
TIG	0.80 mm	12 V - 15 V	60 A - 90A
	1.2 mm	13 V - 16 V	80 A - 110 A
	1.6 mm	14 V - 18 V	90 A - 130 A
	2.4 mm	15 V - 20 V	150 A - 220 A
	3.2 mm	15 V - 20 V	150 A - 220 A
MIG	1.0 mm	26 V - 29 V	150 A- 190 A
	1.2 mm	28 V - 32 V	180 A - 220 A
	1.6 mm	29 V - 33 V	200 A - 250 A