

## SA 308L

**CATEGORY** SAW Submerged arc

**TYPE** Solid stainless steel wire for submerged arc welding (SAW)

**APPLICATIONS** Boilers, agriculture, liquid storage tanks, food machinery, furniture etc.

**PROPERTIES** 308L has good general corrosion resistance. The alloy has a low carbon content, making it particularly recommended where there is a risk of intergranular corrosion.  
Best to be used with our agglomerated flux [FL 8111](#)

**CLASSIFICATION**

AWS	A 5.9: ER 308L
EN ISO	14343-A: S 19 9 L
DIN: W.Nr.	1.4316

**SUITABLE FOR**

W.Nr: 1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4546, 1.4312, 1.4300, 1.4312, 1.4371, 1.4541, 1.4543, 1.4550, 1.4452  
 DIN X2CrNi 19 11 (TP), X4CrNi 18 10 (TP), X6CrNiTi 18 10 (TP), X6CrNiNb 18 10 (TP), X2CrNi 18 10 (TP), X5CrNiNb 18 10, G-X10CrNi 18 8 (TP),  
 AISI 202, 302, 304L, 304, 305, 321, 347, 304 LN  
 ASTM A320 Grade B8C/D, 302

**APPROVALS** CE approved

**WELDING POSITIONS:**



**CAST ANALYSIS**

C	Mn	Si	Cr	Ni	Mo
<0.03	1,7	0,4	18-20	9-10	<0,30

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				+20°C	-40°C	-196°C	
AW	>350	570	35	~120		>50	

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,6			K-300 / K-415	15 / 25	
2,0			K-415	25	
2,4			K-415	25	
3,2			K-415	25	
4,0			K-415	25	

**REDRYING TEMPERATURE** not required