



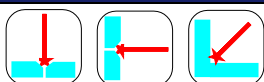
308L XT

AWS A 5.9: ER308L ISO 14343-A: G 19 9 L

DESCRIPTION

Tig wire suitable for welding stainless steels with an alloy content between 16 to 21% Cr and 8 to 13% Ni, stabilised or not. Service temperatures are typically -196°C to about 400°C.

WELDING POSITIONS



POLARITY

DC -

GAS

Ar (I1)

BASE MATERIALS

1.4507, 1.4410, 1.4468, 1.4515, 1.4517, 1.4501

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A₅</i> (%)	<i>KV(j)</i>
630	370	36	+20°C: 110 -60°C: 90

CHEMICAL ANALYSIS(%)

C	Mn	Si	Cr	Ni			
0,02	1,8	0,4	20,0	10,0			

PACKING INFORMATION AND WELDING PARAMETERS

Dimension (mm)	1,2	1,6	2,0	2,4	3,2
Box (kg)	5	5	5	5	5

EQUIVALENT CONSUMABLES

MMA	Meltolit 308L E/308L VD
FCW	Meltolit 308L FCW/FCW-PW
MIG	Meltolit 308L/L XM