


Technical data sheet <small>011121MBA</small>	Cored welding wire TUBE S 308L-S	
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CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22	EC308L
ASME IIC SFA 5.9 / AWS A 5.9	EC308L
EN ISO 17633-A	T 19 9 L M NO 3
Equivalent Material number	1.4316
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Cored stainless steel wire for submerged arc welding
- 19% chromium - 9% nickel - low carbon deposit
- Mineral additions to the core improve mechanical strength and welding characteristics
- Excellent weld metal quality and X-ray soundness
- High productivity
- Enhanced wetting properties compared to matching solid wires
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

APPLICATIONS

TUBE S 308L-S is suitable for welding stainless steels with an alloy content between 16 to 21% Cr and 8 to 13% Ni, stabilised or not.

Examples:

AISI	UNS	Material number	EN Symbol
302	S30200	1.4300	X12 CrNi 18 8
304	S30400	1.4301	X5 CrNi 18-10
304L	S30403	1.4306	X2 CrNi 19-11
304LN	S30453	1.4311	X2 CrNiN 18-10
305	J92701	1.4312	GX10 CrNi 18-8
308	S30800	1.4303	X4 CrNi 18-12
321	S32100	1.4541	X6 CrNiTi 18-10
347	S34700	1.4550	X6 CrNiNb 18-10

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	S	P
0.025	1.50	0.40	21.0	10.0	0.008	0.015

Typical ferrite level: 10 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
520	320	35	-196°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
600	450	40	- 196°C: 50

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

PACKAGING

Diameter	2.0 mm - 3.2 mm
Standard packaging	EN ISO 544 - ASME IIC SFA-5.2 M Coil: B450
Weight	25 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.