

## ❖ Product Description

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|---|---|
| I. Extra low carbon stainless steel solid wire  | IV. Resistance to intergranular corrosion |
| II. Corrosion and scaling resistance upto 800°C | V. Radiographic weld quality              |
| III. Crack resistant weld                       |   |

## ❖ Range of Application

- |   |  |
|---|--|
| I. For welding Cr-Ni steels                       | III. Good for SS piping in refineries, oil and gas industries, chemical plants, food processing industries |
| II. Welding in boilers, reactors, turbines, pipes |  |

## ❖ Classification

- AWS/SFA 5.9 ER308-L

## ❖ % Chemical Composition

Type of Wire		C	Cr	Mn	S	Si	Cu	Mo	P	Ni
ER308-L	Min	-	19.5	1.0	-	0.30	-	-	-	9.0
	Max	0.03	22.0	2.5	0.03	0.65	0.75	0.75	0.03	11.0

## ❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
As Welded	520	-	35	-

## ❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

## ❖ Current & Gas Flow

- DCEP; 15-22lit/min

## ❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

### Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

### **SHAKUNT ENTERPRISES PRIVATE LIMITED**

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