

PRODUCT DATA SHEET

TIG WIRE - PROWELD - 308L/ (1.4316)

Classification: AWS / ASME – A/ SFA 5.9 ER 308L
BS EN 14343: 2009 – W19.9. L

Typical Applications:

Proweld 308L is primarily used for welding austenitic stainless steel of type 304L/1.4306, 304/1.4301 type. This grade can be used to weld stabilized stainless steel grades like 347,321 for low service temperatures. However it is recommended to use Proweld 347Si for service temperature above 350°C. the higher silicon content gives better arc stability and weld fluidity..

Wire Composition: (%)

	C	Mn	Si	Cr	Ni	S	P	Mo
min	-	1.0	0.30	19.5	9	-	-	
max	0.03	2.5	0.65	21.0	11	0.02	0.03	0.30

Corrosion resistance:

Good resistance to general and intergranular corrosion

Packaging Detail:

Diameter : 0.80,1.00,1.20,1.60, 2.0, 2.40, 3.20, 4.0 mm*

Length : 1000 mm (36")

Packing : 5 Kgs in Spiral Tubes/Plastic, then in a Master Carton of 25 Kg(5x5)**

Also available in AWS standard diameters

Mechanical properties (Typical as Weld):

Tensile Strength	600N/mm ²
Yield Strength	400 N/mm ²
Elongation A5	35%
Impact energy(20° C)	120J
-196°C	50 J
Hardness	190 BHN

Marking:

Both ends embossed with grade and diameter for the diameter >=1.60mm

Ferrite content:

Ferrite Number about 9 – WRC-92

Welding Parameters

The information will be provided on request.

Shielding Gas:

I1 Pure Argon, 5-10 L/min

M13 Argon+1-3% O₂, 5-10 L/min