

RAAJMIG ER 308L

Stainless steel continuous & cut length solid welding wire for MIG/TIG welding

CLASSIFICATION : AWS/SFA-5.9: ER308L, BS 19.9.L
DIN 8556: WK. 1.4316

CHARACTERISTICS : ER308L is austenitic Stainless steel welding wire, the weld metal contains ferrite and resistance to crack is extremely good. Low carbon assists austenitic arc stability and improves corrosion resistance such as intergranular type. The mechanical properties of the weld metal are good.

APPLICATION : ER 308L welding wire of low carbon 19%Cr-9%Ni steel for Automobiles and Chemical Industries such as oil, Medical, Fertilizer Textile and Railway Industries and For Nuclear reactors. Designed for welding SS 301, 302, 304, 304L, 308, 308L, 321 and 347 grades.

SHIELDING GAS : welding with 100% Ar gas Or Ar+2%O₂ gas.

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Ni
0.030 max.	1.00-2.50	0.30-0.65	0.030 Max	0.030 Max	9.00-11.00
Cr	Mo	Cu			
19.50-22.00	0.75 max.	0.75 Max			

ALL WELD MECHANICAL PROPERTIES (UNDER Ar GAS SHIELD)

UTS (N/mm ²)	Proof strength (N/mm ²)	EL % (5d)	CHARPY "V" NOTCH IMPACT AT	FERRITE Qty.(FN)
520-660	360-450	35-45	+20 ⁰ C : 100-150 J -196 ⁰ C : 50-70 J	8-10

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIGER308L)

Size(mm)	Size(inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	70-220	16-24	10-20	√	√	X
1.20	0.047	150-300	24-34	15-25	√	√	√
1.60	1/16"	150-350	28-36	15-30	√	√	√

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJTIGER308L)

Size(mm)	Size(inch)	Length (mm)	Length (inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	40-80	10-16	√	√
2.0	5/ 64"	1000	36"	50-100	12-18	√	√
2.4/ 2.5	3/ 32"	1000	36"	60-120	14-20	√	√
3.2	1/ 8"	1000	36"	100-150	16-24	√	√
4.0	5/ 32"	1000	36"	140-200	18-28	√	√

Raajratna offer a wide range of Stainless steel welding wires for MIG/TIG/SA welding.

And also available RAAJMIGER308LSi version for MIG welding process

Customer packing on request.