

RASI ER 308L

TIG / MIG

EXTRA LOW CARBON AUSTENITIC STAINLESS STEEL
SOLID WIRE FOR WELDING

MADE IN INDIA

CHARACTERISTICS

RASI ER 308L 308L has a good general corrosion resistance. The alloy has a low carbon content which makes this alloy particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food processing industries as well as for pipes, tubes and boilers. For joining of stainless steels of 18% Cr - 8% Ni-type with low carbon content and Nb-stabilized steels of the same type if the service temperature will not exceed 350°C. Can also be used for welding of Cr-steels except in sulphur rich environments.

KEY FEATURES

- Excellent corrosion & scaling resistance upto 800°C
- Excellent crack resistance
- Resistance to intergranular corrosion
- Radiographic quality welds

CLASSIFICATIONS

AWS A/SFA 5.9 ER 308L

TYPICAL APPLICATIONS

Welding of similar composition and type 304L, 304, 347, 321 etc. Suitable for welding of piping systems, tubes, boilers in chemical and food processing industries.

WELDING POLARITY

GMAW: DCEP
GTAW: DCEN

Chemical Composition of W/led Metal (wt %)

	C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
Typical Results	0.03 max	1.0 - 2.50	0.3-0.65	0.030 Max	0.025 Max	19.5-22	9-11	0.75 max	---

All Weld Metal Mechanical Properties :-

	UTS (mpa)	YS (mpa)	Elongation %	CVN impact at -20C
Typical Results	520 min	----	36 min.	----

Packing Details :-

	0.80mm	1.00mm	1.20mm	1.60mm	2.0mm	2.40mm	3.2mm	4.00mm
TIG	---	5 kg	5 kg	5 kg	5 kg	5 kg	5 kg	5 kg
MIG	12.5 kg	12.5 kg	12.5 kg	12.5 kg	---	---	---	---

*FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com

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