



AWS	A5.9 ER308L
EN	EN12072 G 19 9 L
JIS	Z3321 Y308L

Characteristics:

It is designed with lower range carbon to help prevent intergranular corrosion. It suitable for welding of low carbon 18%Cr-8%Ni stainless steel such as AISI301, 302, 304L, 308L. It is also used for joining some dissimilar 300 series stainless steel.

Applications:

It is used for oil and gas refineries, stainless steel sheet metal works, rail car fabrication industry include welding of AISI301, 302 and 308 in chemical.

Notes on Usage:

1. For TIG process, use DC(-) current , Argo Shield and Tungsten Electrode.
2. For MIG process, use Spray Transfer or Short Circuit Transfer mode.
3. 98%Argon – 2%O₂ shielding gas is recommended in MIG process.

Typical chemical composition of weld metal (wt%)

C	Cr	Ni	Mn	Si
0.025	20.20	10.30	1.65	0.42

Typical mechanical properties of weld metal

TS N/mm ²	EL %
580	42

Sizes available

MIG Solid Wire(mm)	0.8	0.9	1.0	1.2
TIG Rods(mm)	1.6	2.0	2.4	3.2