



# Cromatig 308L

GTAW - TIG  
Stainless Steel

Date: 2008-01-22  
Revision: 8

## Description:

Cromatig 308L is primarily intended for welding the low carbon 18% Cr / 10% Ni, type 304L, austenitic stainless steels. It is also suitable for stainless steel grade 304 material and the Nb or Ti stabilised grades 347 and 321, provided service temperatures for structural applications are below 400°C.

## Welding current:

DC-

## Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	1,0			19,0	9,0
Typical	0,015	0,40	1,7	0,020	0,010	20,5	10,0
Max	0,030	0,65	2,5	0,030	0,020	21,0	11,0

	Mo	Cu	N
Min			
Typical	0,10	0,10	0,05
Max	0,30	0,30	

## Shielding gas:

Acc. to EN 439:

I1, Ar 99.99%, 6-12 l/min

## Stamping

Elga, AWS, Wst, EN, Batch

## Ferrite content:

FN 9

## Corrosion resistance

Good resistance to general and intergranular corrosion. Also good resistance to oxidising acids and cold reducing acids.

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,015	0,4	1,7	0,02	0,01	20,5	10,0
Max							

	Mo	N
Min		
Typical	0,10	0,06
Max		

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	380 MPa
Tensile Strength, Rm:	≥ 520 MPa	600 MPa
Elongation, A5	≥ 35%	35%
Impact energy, CV:		20°C • 120 J -196°C • 60 J

## Classification:

EN ISO 14343 W 19 9 L  
AWS A5.9 ER308L

## Approvals:

CE

## Product data

Diam.mm	Length mm	Product code
1,2	1000	9803-1012
1,6	1000	9803-1016
2,0	1000	9803-1020
2,4	1000	9803-1024
3,2	1000	9803-1032