

GM 308L

IDENTIFICATION

GM 308L, ER 308L

CLASSIFICATION

AWS/SFA 5.9 ER308L, BS 2901-90 308 S92,
DIN 8556-86 WSGX2 CrNi199

DESCRIPTION

A solid, smooth wire primarily intended for welding the low carbon, 18% Cr, 10% Ni, type 304, austenitic stainless steels. Deposited weld metal has improved resistance to general corrosion. The deposited weld metal is of radiographic quality.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Cu	Mo	S	P
0.030 max	1.0 - 2.5	0.30 - 0.65	19.50 - 22.0	9.0 - 11.0	0.50 max	0.75 max	0.030 max	0.030 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
530 - 650	35 - 45	20°C	100 - 140
		-100°C	40 - 80

TYPICAL APPLICATIONS

- Suitable for welding normal carbon 304, 304L grades and Nb or Ti stabilized steels type 347 and 321 provided service temperatures are below 400°C.
- Widely used for chemical process plants.

CORROSION RESISTANCE:

Good resistance to general and intergranular corrosion oxidizing acids. Good resistance to chlorise pitting corrosion.

FERRITE : Ferrite no. of undiluted weld metal is in the range 3 to 10.

WELDING CURRENT : DC (-)

SHIELDING GAS : Ar + 2 % O₂ , 16 - 21 l/min

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5 / 15.0
1	12.5 / 15.0
1.2	12.5 / 15.0

