

GM 308LT

EXTRA LOW CARBON AUSTENITIC STAINLESS STEEL FILLER ROD.

IDENTIFICATION

GM 308LT, ER 308L

CLASSIFICATION

AWS /SFA 5.9 ER 308L;

DIN 8556-86 WSGX2 CrNi199; BS 2901-90 308S92

DESCRIPTION

An extra low carbon 20/10 filler rod which has excellent resistance to intergranular corrosion due to its extra low carbon content. The weld deposit is corrosion and scale resistant and free from porosity. The deposited weld metal meets X-ray/ radiographic quality. Good resistance to oxidizing acids and reducing adds.

CHEMICAL ANALYSIS (RANGE) %

| C | Cr | Ni | Mo | Si | P | S | Cu | Mn |
|-----------|-----------|------------|---------|-------------|-----------|-----------|----------|-----------|
| 0.025 max | 19.5 - 22 | 9.5 - 11.0 | 0.5 max | 0.30 - 0.65 | 0.030 max | 0.020 max | 0.50 max | 1.0 - 2.5 |

MECHANICAL PROPERTIES (RANGE)

| TS (MPa) | EL (%) (L=4D) | CVN Impact Value | |
|-----------|---------------|------------------|---------|
| | | Temp | Joules |
| 550 - 640 | 35 - 45 | -196°C | 30 - 80 |

TYPICAL APPLICATIONS

- For cryogenic applications such as fabrication of vessels which need guaranteed impact at -196°C
- For welding of 19/10 austentic stainless steel plates of the type AISI 301, 302, 304, 304 L, sheets, pipes and tubes used in chemical plants, fertilizer plants, oil refineries, food and dairy industries.

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 |
| 1.6 | 12.5 / 15.0 |