

SUBARC 308L



Used to weld 18/8 stainless steels including 301, 302, 303, nitrogen bearing 304LN and titanium stabilised 321. Service temperatures are typically -100°C to about 400°C, although solid wires and Ultramet 308LCF are suitable for service down to -196°C. Applications include food, brewery, pharmaceutical equipment, architectural, general fabrication and nuclear engineering.

CLASSIFICATIONS

AWS A5.9 ER308L

CHEMICAL ANALYSIS

% Carbon	0.010	% Chromium	20.00
% Manganese	1.700	% Nickel	10.00
% Silicon	0.400	% Molybdenum	0.100
% Sulphur	0.010	% Copper	0.150
% Phosphorus	0.015	% Ferrite	10.00

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

Tensile Strength	570 MPa
0.2% Proof Stress	450 MPa
Elongation on 4d	41%
Impact Energy -196°C	30J

Microstructure
Austenite with a controlled level of ferrite, normally in the range 2-10FN depending on the application,

* Flux Dependant

PACKING DATA

SAW Wire (DC+)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
2.40	350	28	078-142	25
3.20	380	30	078-144	25
4.00	650	32	078-146	25

Suggested flux : Afrox Flux MH or DX-9

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For more information contact the Afrox Customer Service Centre,
tel: 0860 020202 or e-mail: customer.service@afrox.boc.com
Website: www.afrox.com

