



ER308L

Certifications:

AWS A5.9
ASME SFA A5.9

Features

- This wire is suitable for applications at cryogenic temperatures.
- Ideal for welding types 304L, 321, and 347 stainless steels.

Applications

- Used for high pressure piping and tubing, as well as sheet metal applications on appropriate stainless steel base metals.

Diameters & Packages

Diameter	2 lb	10 lb	25 lb	33 lb	55 lb	60 lb	330 lb	500 lb	36"
0.023"	✓	✓		✓					✓
0.030"	✓	✓		✓					✓
0.035"	✓	✓		✓				✓	✓
0.045"	✓	✓	✓	✓					✓
1/16"			✓	✓		✓		✓	✓
1/8"					✓	✓			✓
3/32"					✓		✓		✓
3/16"						✓			✓
5/32"						✓			✓
5/64"						✓			✓

Technical Specifications

Typical Chemical Composition:

Chemical	C	Cr	Ni	Mn	Si
%	0.02	20.0	10	1.70	0.32

Chemical	P	S
%	0.011	0.009

Recommended Weld Parameters (MIG):

Short Arc Welding

Diameter	Wire Feed	Amps	Volts	Shielding Gas
0.030	13-26	40-120	16-20	Argon+2%O2
0.035	13-26	60-140	16-22	Argon+2%O2

Spray Arc Welding

Diameter	Wire Feed	Amps	Volts	Shielding Gas
0.035	20-39	140-220	24-29	Argon+2%O2
0.045	16-30	160-260	25-30	Argon+2%O2
1/16	10-16	230-350	27-31	Argon+2%O2

Recommended Weld Parameters (TIG):

Diameter	Amps	Voltage	Gases
0.035	60-90	12-15	Argon 100%
0.045	80-110	13-16	Argon 100%
1/16	90-130	14-16	Argon 100%
3/32	120-175	15-20	Argon 100%