GMM MIG 308L

Classification:

Class: AWS : A5.9- ER308L

EN 14343- A : G 19 9 L

Material Conforms to: AWS A5.9 & EN 14343-A

Weld Process Used: MIG (GMAW)

Description:

ER308L carbon content has been held to a maximum of .03% to reduce the possibility of intergranular carbide precipitation. ER308L is ideal for welding Types 304L, 321, and 347 stainless steels. This is a suitable wire for applications at cryogenic temperatures.

Chemical Composition of wire:

Standard Requirement								
C	**Mn**	**Si**	**Cr**	**Ni**	**Mo**	**Cu**	**S**	**P**
0.03 max	1.0-2.5	0.30-0.65	19.5-22.0	9.0-11.0	0.50 max	0.50 max	0.02 max	0.03 max
Average Typical composition								
0.025	1.53	0.43	19.65	9.12	0.30	0.28	0.009	0.027

Mechanical Properties:

Tensile Strength (Min)	Yield Strength (Min)	Elongation (Min)
600 MPa	400 MPa	35%

Available sizes:

- 0.60 mm, 0.80 mm, 0.90 mm, 1.00 mm, 1.20 mm, 1.60 mm

Welding position:

- All position

Polarity:

- DCEP (DC+)

Recommended Welding Parameters:

GMAW "MIG Process"			Reversed Polarity			
	Wire Diameter	Wire Feed	Amps	Volts	Shielding Gas	Gas CFH
Short Arc Welding	0.80	13-26	40-120	16-20	98% Argon+2% O2	25
	0.90/1.00	13-26	60-140	16-22	98% Argon+2% O2	25
Spray Arc Welding	0.90/1.00	20-39	140-220	24-29	98% Argon+2% O2	38
	1.20	16-30	160-260	25-30	98% Argon+2% O2	38
	1.60	10-16	230-350	27-31	98% Argon+2% O2	38

Packing Details:

- 1 Kg/2lbs – SD100
- 5 Kg/10lbs – SD200
- 15Kg/25lbs/33lbs - SD300/BS300
- 100 Kg – Drum Pack
- 250 Kg – Drum Pack

Note: Other shielding Gases may be used for MIG welding. Shielding gases are chosen taking Quality, Cost, and Operability into consideration.