



<h1>GMM TIG 308L</h1>	Classification: Class: AWS : A5.9- ER308L EN 14343- A : W 19 9 L
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Material Conforms to: AWS A5.9 & EN 14343-A

Weld Process Used: TIG (GTAW)

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:

- **Diameter-** 1.20 mm, 1.60 mm, 2.00 mm, 2.40 mm, 3.20 mm, 4.00 mm
- **Length-** 1000 mm & 36" Inch

Welding position:

- All position

Polarity:

- DCEN (DC-)

Recommended Welding Parameters:

<u>GTAW "TIG Process"</u>			
<u>Wire Diameter</u>	<u>Amps DC</u>	<u>Volts</u>	<u>Shielding Gas</u>
1.20	80-110	13-16	Argon 100%
1.60	90-130	14-16	Argon 100%
2.40	120-175	15-20	Argon 100%
3.20	140-200	17-22	Argon 100%

Packing Details:

- 1 Kg/2lbs – Tube
- 5 Kg/10lbs – Tube
- 20Kg/40lbs - Box (4 Tubes)

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