

Stainless solid wire

Classification

AWS A5.9	: ER308L
EN 12072	: W 19 9 L / G 19 9 L

General description

Solid wire with extra low carbon for welding austenitic CrNi-steels
High resistance to intergranular corrosion and oxidizing environments

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	M12	Mixed gas Ar+ >0-5% CO ₂
GMAW	M13	Mixed gas Ar+ >0-3% O ₂

Approvals

	TÜV
GTAW	+

Chemical composition (w%), typical wire / rod

C	Mn	Si	Cr	Ni	Mo
0.010	1.6	0.5	20	10	0.2

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
							+20°C	-196°C
Typical values	GTAW	I1	AW	390	590	35	120	50
	GMAW	M12	AW	390	590	35		

Materials to be welded

Steel grades	EN 10088-11-2	EN 102 13-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Extra low carbon C < 0.03%	X2CrNi19 11		1.4306	(TP)304 L	S30403
			1.4311	CF-3	J92500
Medium carbon C > 0.03%	X2CrNi18 10		1.4301	(TP)304LN	S30453
			1.4308	302, 304	S30400
Ti-,Nb stabilized	X4CrNi18 10		1.4301	(TP)304	S30409
			1.4541	CF-8	J92600
	X6CrNiTi18 10		1.4541	(TP)321	S32100/
			1.4550	(TP)321H	S32109
X6 CrNiNb 18 10		1.4550	(TP)347	S34700	
		1.4552	CF-8C	J92710	

Packaging and available sizes

Process	Unit	Diameter (mm)	1.0	1.6	2.0	2.4	3.2
GTAW	5 and 10 kg tube			X	X	X	X
GMAW	15 kg spool BS300		X				

Other sizes and packaging on request

LNT/LNM 304L: rev. EN 20