

XP ER 308L

STAINLESS STEEL



CLASSIFICATIONS

EN ISO 14343-A	AWS A5.9
W 19 9 L	ER308L

KEY FEATURES AND APPLICATIONS

- Solid corrosion resisting chromium-nickel wire for welding of austenitic chromium nickel alloys of 18% Cr - 8% Ni-type.
- Primarily used for welding stainless-steel base materials of a similar composition, such as 310, 302, 304, 304L, 305, 308, 308L and 347.
- This alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion.
- Ideal for service temperature up to 350°C max.
- Commonly used in the chemical and food processing industries as well as for pipes, tubes and boilers.

BASE MATERIALS

1.4301, 1.4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4546, 1.4550
 X 5 CrNi 18 10, X 2 CrNi 19 11, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10
 AISI 304, 304H, 312, 321H, 347, 347H,
 UNS S30409, S32109, S34709, S30400, S32100, S34700

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
MIN	-	-	1.0	-	-	19.0	9.0	-	-
MAX	0.03	0.65	2.5	0.03	0.02	21.0	11.0	0.5	0.5

Single values are maximum values according to EN ISO 14343

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)
480 (≥320)	635 (≥510)	35 (≥25)

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - I1	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP30314	1.6	1000	5	PAP 20 Tube
XP30318	2.4	1000	5	PAP 20 Tube
XP30320	3.2	1000	5	PAP 20 Tube