OK Tigrod 308L

GTAW
ER308L

Description

Bare, corrosion-resistant, chromium-nickel TIG rod. OK Tigrod 308L has good general corrosion resistance. The alloy has a low carbon content which makes it particularly recommended when there is a risk of intergranular corrosion.
The alloy is widely used in the chemical and food-processing industries, as well as for pipes, tubes and boilers. Suitable forthe joining of stainless steels of the18% Cr-8% Ni type with a low carbon content and Nb-stabilised steels of the same type if the service temperaturedoes not exceed 350ºC. It can also be used for welding Cr steels, except in sulphur-rich environments.

Welding current

DC(-)

Classifications

SFA/AWS A5.9	ER308L
EN 12072	W 19 9 L
Werkstoffnummer	~1.4316

Wire composition

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.5	1.8	20.3	10.0	<0.3	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	450
Tensile strength, MPa	645
Elongation, %	36

Charpy V

Test temps, °C	Impact values, J
+20	170
-80	135
-196	90

Approvals

DNV	308L (-60ºC)
UDT	DIN 8556
VdTÜV	

Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.2	1000	5
1.6	1000	5
2.0	1000	5
2.4	1000	5
3.2	1000	5