



Cromasaw 308L

SAW-Submerged arc welding
Stainless Steel

Date: 2004-04-15
Revision: 4

Description:

Cromasaw 308L is a submerged arc wire for use in combination with Cromaflex 300B to weld the low carbon 18% Cr / 10% Ni type austenitic stainless steels. Also suitable for welding normal carbon grades (304) and Nb or Ti stabilised grades (347, 321) if service temperatures are below 400°C.

	C	Si	Mn	P	S	Cr	Ni
Min		0,3	1,0			19,5	9,0
Typical	0,015	0,4	1,8	<0,015	<0,015	20,0	10,0
Max	0,03	0,65	2,5	0,03	0,03	22,0	11,0

Ferrite content:

FN 7

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,015	0,6	1,4	<0,015	<0,015	19,5	10,0
Max							

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 320 MPa	390 MPa
Tensile Strength, Rm:	≥ 520 MPa	550 MPa
Elongation, A5	≥ 35%	36%
Impact energy, CV:	-196°C • >40 J	-196°C • 60 J

Product data

Product code	Diam.mm	Current A	Voltage V
9803-5024	2,4	300-500	26-30
9803-5032	3,2	300-500	28-30
9803-5040	4,0	300-500	28-32
		300-500	

Classification:

EN 12072	S 19.9.L
AWS A5.9	ER 308L
BS 5465	308 S92
DIN 8556	X2 CrNi 19.9
Werkstoff no.	1.4316

Approvals:

TÜV
DNV

Note

TR approved until 12 mm.