

Classifications

EN ISO 14343-A	AWS A5.9 / SFA-5.9
S 19 9 L	ER308L

Characteristics and typical fields of application

SAW wire of S 19 9 L / ER308L type for joining and surfacing applications with matching and similar stabilized and non-stabilized austenitic CrNi(N) and CrNiMo(N)-steels/cast steel grades. Resistant to intercrystalline corrosion and wet corrosion up to 350°C. Corrosion resistance similar to matching low-carbon and stabilized austenitic 18Cr-8Ni(N)-steels and cast steel grades. Good toughness at subzero temperatures as low as -196°C.

Recommended SAW flux:

Marathon 104
 Marathon 213
 Marathon 431

Base materials

1.4301 X5CrNi18-10, 1.4306 X2CrNi19-11, 1.4307 X2CrNi18-9, 1.4311 X2CrNi18-9, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10
 UNS S30400, S30403, S30453, S32100, S34700
 AISI 304, 304L, 304LN, 302, 321, 347
 ASTM A157 Gr. C9, A320 Gr. B8C or D

Typical analysis

	C	Si	Mn	Cr	Ni
wt.-%	0.015	0.45	1.6	20.0	10.0

Operating data

Dimension mm	Current A	Voltage V
1.6	200 – 300	26 – 30
2.4	300 – 400	29 – 33
3.2	350 – 500	29 – 33
4.0		

Approvals

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