

### Classification

AWS A 5.9: ER 308 L    EN 12072: W 19 9 L

### Typical weld metal chemical composition (%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.03 max	1.50-2.20	0.30-0.65	19.50-22.00	9.00-11.00	0.75 max.	0.25 max.	0.03 max.	0.03 max.

### All weld metal mechanical properties (typical)

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Impact energy ISO-V(J) 20°C
≥ 350	≥ 550	≥ 35	≥ 47

### Description

ITR 308L is a 20 Cr / 10 Ni stainless steel TIG welding wire similar in composition to ER 308L, suitable for welding of austenitic stainless steels such as 18 Cr/ 8 Ni type, AISI 304, 304L, 308 and 308L type of steels. Excellent corrosion resistance and Good mechanical properties. Ferrite is controlled between 3% to 8 %. Extra low carbon increases intergranular corrosion resistance. Excellent crack resistance.

### Materials to be welded

Steel Grades	EN 10088-1/-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 CF-3	S30403 J92500
	X2CrNi18 10		1.4311	(TP)304LN 302, 304	S30453 S30400
Medium carbon (C>0.03%)	X4CrNi18 10	GX5CrNi19 10	1.4301 1.4308	(TP)304 CF-8	S30409 J92600
	X6CrNiTi18 10		1.4541	(TP)321 (TP)321H	S32100 S32109
Ti-, Nb stabilized	X6 CrNiNb 18 10	GX5 CrNiNb 19 10	1.4550 1.4552	(TP)347 CF-8C	S34700 J92710

### Current conditions

DC (-)

### Storage

Keep dry and avoid condensation

### Corrosion resistance

Corresponding to ER308L, i.e. fairly good under severe conditions such as oxidising and cold dilute reducing acids.

### Packing data

Size (mm) DxL	0.80 x 1000	0.90 x 1000	1.00 x 1000	1.20 x 1000	1.60 x 1000	2.00 x 1000	2.40 x 1000	3.20 x 1000	4.00 x 1000
Net wt. per tube (kg)	5	5	5	5	5	5	5	5	5
Net wt. per box (kg)	20	20	20	20	20	20	20	20	20

### Welding positions

