



FW 308L



**CODIFICATION: AWS/SFA 5.9
ER308L**

CHARACTERISTICS AND APPLICATIONS:

FW 308L is a solid wire for TIG process, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. Wire contains low carbon 20Cr - 10Ni. The weld metal exhibits excellent resistance to Intergranular Corrosion. It is ideally suited for welding of stainless steels of similar composition like 304L and equivalents, for overlays, surfacing, and repairing castings of similar materials.

CHEMICAL COMPOSITION OF SOLID WIRE (%):

Element	C	Mn	Si	S	P	Cr	Ni
Range	0.03 Max	1.0- 2.5	0.30- 0.65	0.03 Max	0.03 Max	19.5- 22.0	9.0- 11.0
Typical	0.022	1.20	0.40	0.015	0.018	20.0	10.0

MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (MPa)	Elongation (L=4d) %
Range	520 Min	35 Min
Typical	570	40.0

SHIELDING GAS : Argon

CURRENT CONDITIONS : DCEN

WELDING POSITIONS :

PACKING:

Standard Size	Diameter 1.6 mm, 2.0 mm, 2.5 mm & 3.2 mm in cut lengths of 1000 mm each.
Quantity	5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on both the sides of wire.

An ISO 9001: 2008 certified company

D & H Sécheron Electrodes Pvt. Ltd.

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