



Techalloy 308/308L

Description

Techalloy 308/308L is used for TIG, MIG, and submerged arc welding of type 304 stainless steel. The carbon content has been held to a maximum of 0.03% to reduce the possibility of inter-granular carbide precipitation. This filler metal is the most popular grade among stainless steels, used for general purpose applications where corrosion conditions are moderate. It should not be used for mild steel to stainless joining applications.

Specifications & Approvals:

AWS A5.9 ER308/308L UNS S30880/S30883 ISO 14343:2009 (19 9 L) CWB

Typical Chemical Composition

C	Mn	Si	Cr	Mo	Ni	Nb	N	S	P	Cu	FN (WRC)
.019	1.72	.46	20.80		10.10			.003	.013		8

Typical Mechanical Properties

Tensile Strength	88,500 PSI	610 MPA
Yield Strength	59,500 PSI	410 MPA
Elongation	39%	

Welding Parameters

	Shielding	Gas Flow	Diameter	Voltage	Amperage
Mig Welding	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO2	30 to 50 CFH	.035" (0.9mm) .045" (1.14mm) .062" (1.6mm))	26 to 29 28 TO 32 29 TO 33	160/210 180/250 200/280
Tig Welding					
Sub Arc Welding	Suitable flux may be used		3/32" (2.5mm) 1/8" (3.14mm) 5/32" (4.0mm)	28 to 33 29 TO 32 30 TO 33	275/350 350/450 400/550

Standard Packages:

Mig Wire– 33# wire basket	Tig Wire– 10# tube/30# Master Carton	SAW– 60# Coil
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