

ER308LCF

SAW

SOLID WIRES FOR CRYOGENIC 304L APPLICATIONS

PRODUCT DESCRIPTION

Batch selected solid wire for sub-arc welding.

CLASSIFICATIONS

AWS A5.9M	ER308L
ISO 14343-A	S 19 9 L
ISO 14343-B	SS308L

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	--	1.0	0.30	--	--	19.5	9.0	--	--	3
Max.	0.025	2.0	0.65	0.020	0.030	21.0	11.0	0.3	0.3	8
Typical	0.01	1.7	0.4	0.01	0.015	20	10	0.1	0.15	7

ALL-WELD MECHANICAL PROPERTIES

As welded	Min.	Typical SAW + P2007
Tensile strength [MPa]	510	550
0.2% proof strength [MPa]	320	390
Elongation [%] 4d	30	41
5d	30	37
Impact ISO-V[U] -130°C	--	50
-196°C	--	45
Lateral expansion * [mm] -196°C	0.38	0.5

* ER308LCF SAW wire batch tested, with P2007 flux, for Charpy lateral expansion >0.38mm at -196°C.C.

TYPICAL OPERATING PARAMETERS

	Flux	Current	Diameter (mm)	Parameters
SAW	P2007	DC+	2.4	350A,30V

PACKAGING DATA

Diameter [mm]	Weight [kg]	Packaging	Item number
2.4	25	B415	SAER308LCF24
3.2	25	B415	SAER308LCF32

STAINLESS STEELS