Techalloy® 308/308L

AWS ER308L

CONFORMANCES

AWS A5.9 ER308L
UNS S30880/S30883
ISO 14343:2009 (19 9 L)

Techalloy® 308/308L electrodes give a weld deposit, with reduced carbon levels (0.04% max) that offers increased resistance to inter-granular corrosion. Type 308L is ideal for welding Type 304L stainless steels.

Applications: 304 Steels

DIAMETERS / PACKAGING

Diameter in	(mm)	MIG WIRE 33 lb (14.9 kg) Wire Basket	TIG WIRE 10 lb (4.5 kg) Tube 30 lb (13.6 kg) Master Carton	SAW WIRE 55 lb (25 kg) Coil
*0.035	(0.9)	MG308L035667		
*0.045	(1.2)	MG308L045667		
1/16	(1.6)	MG308L062667	TG308L062638	SA308L062726
3/32	(2.4)		TG308L093638	SA308L093726
1/8	(3.2)		TG308L125638	SA308L125726
5/32	(4.0)		TG308L156638	SA308L156726

* Bulk packaging available - Contact Lincoln Electric

Publication C14.10.43 | Issue Date 06/13

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LINCOLN ELECTRIC
THE WELDING EXPERTS®

DEPOSIT COMPOSITION

	%C	%Cr	%Ni	%Mo	%Mn
Requirements AWS ER308L	0.03 max	19.5 - 22.0	9.00 - 11.00	0.75 max.	1.0 - 2.5
Typical Performance Techalloy® 308/308L	0.01	19.7	9.7	0.17	1.7
	%Si	**%P**	**%S**	**%Cu**	**FN**
Requirements AWS ER308L	0.30 - 0.65	0.03 max	0.03 max.	0.75 max.	Not Required
Typical Performance Techalloy® 308/308L	0.37	0.02	0.01	0.18	8 - 14

TYPICAL OPERATING PROCEDURES

Process	Diameter in (mm)	Voltage (volts)	Amperage	Gas Flow	Gas
MIG	0.035 (0.9) 0.045 (1.2) 0.062 (1.6)	26-29 28-32 29-33	160-210 180-250 200-280	30-50 CFH	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO_2
TIG	1/16 (1.6) 3/32 (2.4) 1/8 (3.2) 5/32 (4.0)		90-130 120-175 150-220 160-230	20 - 40 CFH	100% Argon
SAW	1/16 (1.6) 3/32 (2.4) 1/8 (3.2) 5/32 (4.0)	28-33 29-32 30-33	275-350 350-450 400-550	275-350 350-450 400-550	Lincolnweld® P2007

Material Safety Data Sheets (MSDS) are available on our website at www.techalloy.com

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