

Blue Max® Orbital TIG 308/308L

Stainless Steel • AWS ER308, ER308L

Key Features

- ▶ Ultra clean wire
- ▶ Q2 Lot® - Certificate showing actual wire composition and calculated ferrite number (FN) available online
- ▶ Batch Managed Inventory

Typical Applications

- ▶ Process Piping
- ▶ Thermal Energy
- ▶ Petroleum Processing

Conformances

AWS A5.9/A5.9M: 2006 ER308, ER308L
 ASME SFA-A5.9: ER308, ER308L

Welding Positions

All

Shielding Gas

100% Argon

DIAMETERS / PACKAGING

Diameter in (mm)	2 lb (0.9 kg) Spool 8 lb (3.6 kg) Carton	10 lb (4.5 kg) Spool
0.035 (0.9)	ED034153	ED034155

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(AWS ER308; ER308L)

DEPOSIT COMPOSITION⁽¹⁾ – As Required per AWS A5.9/A5.9M: 2006

	%C	%Mn	%Si	%S	%P	%Cr
Requirements						
AWS ER308L	0.03 max.	1.0 - 2.5	0.30 - 0.65	0.03 max.	0.03 max.	19.5 - 22.0
Test Results⁽²⁾	0.02	1.30	0.40	<0.01	0.02	20.30
	%Ni	%Mo	%Cu	%N	FN	
Requirements						
AWS ER308L	9.0 - 11.0	0.75 max.	0.75 max	Not Specified	Not Required	
Test Results⁽²⁾	10.20	0.16	0.10	0.02	Not Required	

⁽¹⁾ Typical all weld metal. ⁽²⁾ See test results disclaimer below.

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

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