

308S92

SAW

SOLID WIRE FOR SAW

PRODUCT DESCRIPTION

Solid wire for sub-arc welding.

CLASSIFICATIONS

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

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 3

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	12
Typical	0.01	1.7	0.4	0.01	0.015	20	10	0.1	0.15	10

ALL-WELD MECHANICAL PROPERTIES

As welded	Typical SAW + P2007
Tensile strength [MPa]	570
0.2% proof strength [MPa]	450
Elongation (%) 4d	41
5d	37
Impact ISO-V(I) -130°C	50
-196°C *	30
Hardness cap/mid (HV)	195/215

* For applications requiring cryogenic toughness see data sheet B-37.

EXAMPE OF OPERATING PARAMETERS

Flux	Current	Diameter (mm)	Parameters
P2007**	DC+	2.4	350A,28V

**SSB also suitable.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
2.4	25	B415	SA308S92-24
3.2	25	B415	SA308S92-32
4.0	25	B415	SA308S92-40