

ER308LCF

TOP FEATURES

- Controlled ferrite grade for impact at -196°C
- Recommended to be used with P2007 or SSB flux
- Supplied in 25kg precision layer wound spools

CLASSIFICATION

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

CURRENT TYPE

DC+

CHEMICAL COMPOSITION (WEIGHT %), WIRE

	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

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded	Min.	Typical
Tensile strength (MPa)	510	605
0.2% Proof strength (MPa)	320	465
Elongation (%) 4d	30	35
5d	30	33
Impact ISO-V (J) -130°C		110
-196°C		80
Lateral expansion* (mm) -196°C	0.38	1.0

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

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.4	SPOOL	25.0	SAER308LCF24
3.2	SPOOL	25.0	SAER308LCF32

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

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.