

# Blue Max<sup>®</sup> MIG 308LCF

Stainless • AWS ER308/308L

## Key Features

- ▶ Controlled Low Ferrite (Range 3-6)
- ▶ Charpy V-Notch test results capable of exceeding 27 J (20 ft•lbf) @ -196°C (-320°F)
- ▶ Exceeds 15 mils (0.38 mm) of lateral expansion @ -196°C (-320°F)
- ▶ Q2 Lot<sup>®</sup> - Certificates showing actual wire chemistry available online
- ▶ Batch Managed Inventory

## Typical Applications

- ▶ LNG Storage
- ▶ Cryogenic Vessels and Piping

## Conformances

- AWS A5.9:** ER308/308L  
**ASME SFA-A5.9:** ER308/308L

## Welding Positions

- ▶ All

## Shielding Gas

- ▶ 98% Argon / 2% Oxygen

## Typical Base Metals

- ▶ 304L stainless steel
- ▶ 18/8 steels with service temperatures down to -196°C (-320°F)

## DIAMETERS / PACKAGING

Diameter in (mm)		33 lb (15kg) Steel Spool
0.035	(0.9)	ED034909
0.045	(1.1)	ED034910

## MECHANICAL PROPERTIES<sup>(1)</sup>

	Yield Strength <sup>(2)</sup> MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft•lbf) -196°C (-320°F)	Lateral Expansion mils (mm) -196°C (-320°F)
<b>Requirements</b> AWS A5.9: ER308/308L As-Welded with 98% Ar/2% O <sub>2</sub>	Not Specified	Not Specified	Not Specified	Not Specified	Not Specified
<b>Typical Performance<sup>(3)</sup></b> As-Welded with 98% Ar/2% O <sub>2</sub>	430 (63)	600 (88)	35	34 (47)	24 (0.61)

<sup>(1)</sup>Typical all weld metal <sup>(2)</sup>Measured with 0.2% offset <sup>(3)</sup>See test results disclaimer below

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(AWS ER308/308L)

*Material Safety Data Sheets (MSDS) are available upon request.*

**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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