

## Filler rod and wire

**Features:** • Suitable for low carbon 18%Cr-8%Ni steel

**Classification:** AWS A5.9 ER308L

**Shielding gas:** Ar

**Identification color:** 1st Red

**Polarity:** DCEN

## Packaging data

ϕ mm	Spool		Tube	
	kg	kg	Length mm	g/piece
0.8	10	5	1,000	4
1.0	10	5	1,000	6
1.2	10	5	1,000	9
1.6	10	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
3.2	-	5	1,000	64
<b>Volume mm</b>	240W, 110H, 240L		40W, 35H, 1015L	

## Composition (rod and wire mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.01	0.03
<b>Si</b>	0.37	0.30~0.65
<b>Mn</b>	1.8	1.0~2.5
<b>P</b>	0.02	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	10.1	9.0~11.0
<b>Cr</b>	19.8	19.5~22.0
<b>Mo</b>	0.07	0.75
<b>Cu</b>	0.08	0.75

Note: <sup>a</sup> Single values are maximum.

## Welding parameters

ϕ mm	Current A
0.8	50~80
1.0	50~80
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250
3.2	200~300

## All-weld mechanical properties

	Typical
<b>0.2%YS (MPa)</b>	420
<b>TS (MPa)</b>	590
<b>EI on 4d (%)</b>	45
<b>IV -196°C (J)</b>	78

## Approvals

<b>ABS</b>	AWS A5.9 ER308L
<b>LR</b>	MG
<b>DNV</b>	NV308L, MG
<b>BV</b>	308LBT, UP
<b>NK</b>	KY308L
<b>GL</b>	4306
<b>CCS</b>	AS1-A