

Material Type		
AISI 304L	1.4306	X2CrNi19-11

Characteristics
WAAM solid wire designed for 3Dprinting of austenitic alloy 304L structures.

Typical analysis of the solid wire (wt.-%)					
	C	Mn	Cr	Ni	N
wt.-%	0.02	1.6	20.0	10.0	<0.1

Post weld heat treatment to increase toughness or strength.

Available products
Diameter: 1,0 mm – 1,2 mm
Package: BS300 15 kg – ECOdrum 100 – ECOdrum 250 – S760 300
Other diameters and packages on request.

Typical mechanical properties acc. to EN ISO 15792-1			
Heat treatment	Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation ( $L_0=5d_0$ )
	MPa	MPa	%
u	380	620	48
u untreated, shielding gas Ar + 2 % CO <sub>2</sub> , DC+			

Classification as welding consumable:

EN ISO 14343-A	AWS A5.9
G 19 9 L	ER308L