



UP 308L S.S. SAW WIRE

Classification

AWS A 5.9 : ER308L Material N : 1.4316
ISO 14343-A : S 19 9 L

Characteristics

Solid wire for submerged arc welding of 18/8 – 304L type stainless steels used at service temperatures from -196°C up to +350 °C.

Applications

Tubes, Tanks, Heat Exchangers, Piping systems.

Base materials

UNS	Alloy	EN 10088	Material. N ^o	UGINE
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B, D, E
S30403	304L	X2CrNi19-11	1.4306	UGINOX 18-10 L
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb18-10	1.4550	

Typical Wire Composition (%)

C	Si	Mn	Cr	Mo	Cu	P	S	Ni	Fe
0.010	0.500	1.900	19.700	0.500	0.060	0.010	0.010	10.500	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R _m (MPa)	YS R _{p0.2} (MPa)	% Elg A _{5d}	Impact (KV) Temp. °C J
AW	560	400	35	+20°C 90 -196°C 50

Welding Parameters

Process	Ø (mm)	Welding Parameters			Flux
		Current (A)	Voltage (V)	Speed cm/min	
SAW	2.4	300 – 350	26 – 28	45 – 55	UP-WP380 UP-WP380M UP INOX L
	2.8	350 – 420	26 – 28	45 – 55	
	3.2	450 – 500	26 – 28	45 – 55	

Packing

Available in 25 kg Spool.