

## Classifications

AWS A5.9	EN ISO 14343-A	GB/T 5092
ER308L	G 19 9 L	H 03 Cr 2 Ni 10 Si

## Characteristics and typical fields of application

- GMAW solid wire of type G 19 9 L / ER308L designed for high quality welding, good wetting and feeding characteristics and excellent weld metal CVN values down to -196 °C
- Resistance to intergranular corrosion up to +350°C

## Base materials

1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2CrNiN18-10.  
 1.4312 GX10CrNi18-8, 1.4541 X6CrNiNTi18-10, 1.4546 X5CrNiNb18-10,  
 1.4550 X6CrNiNb18-10.  
 AISI 304,304L,304LN,302,321,347, AWS A157 Gr.C9; A320 GR.B8C or D

## Typical analysis of all-weld metal

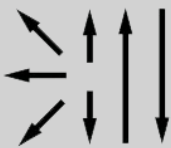
	C	Si	Mn	P	S	Cr	Ni		
wt-%	0.02	0.50	1.8	0.015	0.015	20.0	10.2		

## Mechanical properties of all-weld metal – typical values (min. values)

Condition	Yield strength $R_{p0,2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-196 °C
AW	430 (≥ 320)	580 (≥510)	40(≥ 30)	100 (≥ 47)	≥32

AW as welded

## Operating data

	Polarity:	Shielding gas:	∅ mm
	DC +	(ISO14175) M13	0.8
			1.0
			1.2
			1.6

## Approvals

CE