



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 308L

Prepared by Mats Linde	Qualified by P-O Oskarsson	Approved by Jay A Coubrough	Reg no EN007502	Cancelling EN007475	Reg date 2017-03-22	Page 1 (2)
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REASON FOR ISSUE

Updated Chemistry Data

GENERAL

Bare corrosion resisting chromium-nickel rods. OK Tigrod 308L has a good general corrosion resistance. The alloy has a low carbon content which makes this alloy particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food processing industries as well as for pipes, tubes and boilers.

For joining of stainless steels of 18% Cr - 8% Ni-type with low carbon content and Nb-stabilized steels of the same type if the service temperature will not exceed 350°C.

Can also be used for welding of Cr-steels except in sulphur rich environments.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C

CLASSIFICATIONS Wire Electrode

EN ISO 14343-A W 19 9 L
SFA/AWS A5.9 ER308L
Werkstoffnummer ~1.4316

APPROVALS

CE EN 13479
CWB ER308L
DNV-GL VL 308 L (I1)
NAKS/HAKC 1.6-2.4 mm
VdTÜV 04269

APPROVAL COMMENT

Valid for lot numbers starting with PV

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.01		0.030
Si	0.4	0.30	0.65
Mn	1.8	1.5	2.0
P	0.020		0.030
S	0.015	0.005	0.020
Cr	20	19.5	21.0
Ni	10	9.0	11.0
Mo	0.1		0.50
Cu	0.1		0.50
N			0.080
FN WRC-92		5	12
Others tot			0.50



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MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	As welded	
	Min	Typ
Rp0.2 (MPa)	320	440
Rm (MPa)	510	580
A4-A5 (%)	30	36
Charpy V at 20°C (J)		170
Charpy V at -80°C (J)		135
Charpy V at -196°C (J)		80