Inweld 308L

AWS A5.9 ER308L

Chemical Composition of Inweld 308L

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	Cu
Balance	0.03	19.5-22.0	9.0-11.0	0.75	1.0-2.5	0.30-0.65	0.03	0.03	0.75

Single values are maximum unless otherwise specified.

Description and Applications

Inweld 308L is similar to Inweld 308 but contains an average of 0.025% carbon producing a weld deposit with great resistance against inter-granular corrosion caused by carbide precipitation. This is probably the most popular grade among the stainless steel alloys. It is used for general purpose applications where corrosion conditions are moderate. Inweld 308L should not be used for a mild steel to stain less joining applications. Used more commonly for welding AISI types 304L, 308L, 321, and 347.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	88,500 psi
Yield Strength:	59,500 psi
Elongation:	39%

Recommended Parameters

GMAW (DCEP – Electrode+) short circuit transfer: 98% Argon 2% Oxygen; Spray transfer: Trimix 90% Helium, 7.5% Argon and 2.5% Carbon Dioxide.

Wire Diameter	Voltage	Amperage
0.035”	26-29	160-210
0.045”	28-32	180-250
1/16”	29-33	200-280

GTAW (DCEN – Electrode -) 100% Ar 2% Thoriated

Filler Wire Size	Tungsten Dia.	Voltage	Amperage	Argon (CFH)
1/16”	1/16”	12	80-150	20
3/32”	3/32”	12	150-250	20
1/8”	1/8”	12	200-375	25

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