

## ER308LCF

TIG (GTAW)

## SOLID WIRES FOR CRYOGENIC 304L APPLICATIONS

## PRODUCT DESCRIPTION

Batch selected solid wire for TIG welding.

## CLASSIFICATIONS

AWS A5.9M	ER308L
ISO 14343-A	W 19 9 L
ISO 14343-B	SS308L

## ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

## CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	--	1.0	0.30	--	--	19.5	9.0	--	--	3
Max.	0.025	2.0	0.65	0.020	0.030	21.0	11.0	0.3	0.3	8
Typical	0.01	1.7	0.4	0.01	0.015	20	10	0.1	0.15	7

## ALL-WELD MECHANICAL PROPERTIES

As welded	Min.	Typical
Tensile strength (MPa)	510	605
0.2% proof strength (MPa)	320	465
Elongation (%) 4d	30	35
5d	30	33
Impact ISO-V(U) -130°C	--	110
-196°C	--	80
Lateral expansion * (mm) -196°C	0.38	1.0

## TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon	DC-	2.4	100A, 12V

## PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	5	PE TUBE	TER308LCF-16
2.0	5	PE TUBE	TER308LCF-20
2.4	5	PE TUBE	TER308LCF-24
3.2	5	PE TUBE	TER308LCF-32

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to [www.specialalloys.eu](http://www.specialalloys.eu) for any updated information.