



DESCRIPTION

Executive 308L has the same analysis as type 308 except the carbon content has been held to a maximum of .03% to reduce the possibility of intergranular carbide precipitation. This increases the resistance to intergranular corrosion without the use of stabilizers such as columbium (niobium) or titanium. Ideal for welding Types 304L, 321, and 347 stainless steels. Strength of this low-carbon alloy, however, is less than that of the columbium (niobium)-stabilized alloys or Type 308H at elevated temperatures. This is a suitable wire for cryogenic applications, depending on temperature range, process control variables and flux selection. Contact our technical department for assistance on cryogenic applications. Product is available in 33-lb, 60-lb, and 250-lb **X-PAK**.

TYPICAL CHEMICAL VALUES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.02	20.0	10.0	0.75	1.7	0.4	0.02	0.02	0.75

WELDING PARAMETERS

PROCESS	SIZE	VOLTS	AMPS	SPEED OF WELDING / GAS FLOW	SHIELDING GAS / FLUX
SAW	.093	29 - 32	300 - 350	20 - 30 IPM	Record IN Flux
	.125	29 - 32	400 - 550	20 - 30 IPM	Record IN Flux
	.156	29 - 32	500 - 650	20 - 30 IPM	Record IN Flux
GMAW	.035	29 - 33	160 - 180	30 - 50 CFH	98/99% Ar + 2/1% O ₂
	.045	29 - 33	180 - 220	30 - 50 CFH	or
	.062	29 - 33	210 - 250	30 - 50 CFH	97% Ar + 3% CO ₂
GTAW	.093	Direct Current; Electrode –		30 - 40 CFH	100% Ar

MECHANICAL PROPERTIES

Tensile Strength:	85,000 PSI	590 MPA
Yield Strength:	57,000 PSI	390 MPA
Elongation:	35%	

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.9, Class ER308L**, and is certified by the Canadian Welding Bureau to AWS A5.9. ISO 14343A, Class 19 9 L and ISO 14343B, Class SS308L.