

DESCRIPTION

Executive 308/308L has the same analysis as type 308 except the carbon content has been held to a maximum of 0.03% 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.

Strength of this low-carbon alloy, however, is less than that of the niobium-stabilized alloys or Type 308H at elevated temperatures.

Executive stainless-steel filler metal is produced to a very clean and consistent standard which aids in weldability.

APPLICATIONS & FEATURES

This wire is ideal for welding Types 304L, 321, and 347 stainless steels. This is a suitable wire for cryogenic applications, depending on temperature range, process control variables and flux selection.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.013	19.75	10.37	0.14	1.55	0.41	0.023	0.018	0.14
Tensile Strength:	85,000 PSI min		Elongation:	35%		Ferrite Range:	7- 11 FN (WRC-92)	
Yield Strength:	57,000 PSI min							

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short - Spray	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar
	.045"	22-23	180-210		
	.062"	23-24	200-220		
	.035"	23-25	190-260		
	.045"	25-28	250-330		
	.062"	28-31	310-350		
GTAW	.093" & .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.093"	29-32	300-350		Record IND 24 or Record IN
	.125"	29-32	400-550		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet



CLASSIFICATION

AWS/SFA 5.9, Class **ER308/308L**
Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.