

## 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	
<b>Tensile Strength:</b>		85,000 PSI min		<b>Elongation:</b>		35%		<b>Ferrite Range:</b> 7- 11 FN (WRC-92)	
<b>Yield Strength:</b>		57,000 PSI min							

## TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
<b>GMAW</b> - Short - Spray	.035"	21-22	160-200	30 to 50 CFH	98% Ar / 2% O <sub>2</sub>
	.045"	22-23	180-210		
	.035"	23-25	190-260		90% Ar / 10% O <sub>2</sub>
	.045"	25-28	250-330		
<b>GTAW</b>	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
<b>SAW</b>	.093"	29-32	300-350	Record IN Flux	
	.125"	29-32	400-550		

## STANDARD PACKAGING

<b>GMAW</b> (MIG)	33-lb wire baskets	40-lb box	1,980-lb pallet
	11-lb plastic spools		11-lb box
	2-lb plastic spools		8-lb box
<b>GTAW</b> (TIG)	10-lb plastic tube		
<b>SAW</b>	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.