

MIGINOX 308L / TIGINOX 308L

Classification
AWS A/SFA 5.9 : ER 308L

Approvals : MIGINOX 308L
RDSO Class VI

Approvals : TIGINOX 308L
NPCIL
TOYO ER 308L

Characteristics

An extra low carbon 20 Cr/10 Ni stainless steel filler wire for MIG welding of austenitic chromium nickel stainless steels of 18 Cr / 8 Ni type. The controlled ferrite content of 3% to 8% in the weld ensures excellent crack resistance. The extra low carbon content increases resistance to inter-granular corrosion.

Typical Applications

For welding of stainless steels represented by AISI types 301, 302, 304 and 308 having low carbon content, used in chemical and food processing industries, as well as for pipes, tubes and boilers.

Wire Chemistry

| C | Mn | Si | Cr | Ni | S | P |
|----------|-------|-----------|-----------|------|----------|----------|
| 0.03 max | 1-2.5 | 0.30-0.65 | 19.5-22.0 | 9-11 | 0.03 max | 0.03 max |

Properties of weld metal with 98% Ar + 2% O₂ gas shielding Current Condition:DC (+) in GMAW

Classifications:

All Weld Mechanical Properties As welded condition

| | |
|----------------------|-----|
| UTS MPa | 520 |
| Elongation % (L=4xd) | 40 |

The chemistry and mechanical properties of the weld metal will vary with the type of shielding gas used.

Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 12.5 Kg

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

Packing Specifications for MIGINOX 308L

| | | | | |
|---------|------|------|------|------|
| Size mm | 2.0 | 1.6 | 1.2 | 0.80 |
| Kgs | 12.5 | 12.5 | 12.5 | 12.5 |

Packing Data for TIGINOX 308L

| | | | |
|-----------------------------|------|------|------|
| Dia., mm | 1.6 | 2.0 | 2.5 |
| Length,mm | 1000 | 1000 | 1000 |
| Net wt per tube,kg | 5 | 5 | 5 |
| No of Plastic Tubes per Box | 4 | 4 | 4 |
| Net wt,Box,kg | 20 | 20 | 20 |

Special Test :

| Test Type | Remarks |
|---------------------------|---|
| IGC (As per ASTM - A 262) | * TIGINOX - 308L passed in practice - "E" |
| | * MIGINOX - 308L passed in practice - "E" |



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