



# WB308LM M.I.G. WELDING WIRE

**Classifications**

AWS A5.9-81 : ER308L

BSEN12072-00 : G19 9L

**Product Description**

308L stainless steel, solid MIG wire.

**Applications**

WB308LM is suitable for the repair and welding of wrought and cast alloys such as 304, 304L, C12 and 304.S.62 . Suitable for use in corrosive environments up to 400°C.

Also suitable for welding type 321 stabilised grade, in addition to types 301, 302 and 303.

Typical applications :- food, pressure vessels, valves and general stainless steel engineering.

Ferrite in the 3-8 FN range.

**Wire Composition(Weight %)**

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
<b>min.</b>	-	1.0	0.30	-	-	19.5	9.0	-	-
<b>max.</b>	0.03	2.5	0.65	0.03	0.03	22.0	11.0	0.5	0.50

**Typical All-Weld Metal Mechanical Properties**

Ultimate Tensile Strength	N/mm <sup>2</sup>	510 min.
Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	320 min.
Elongation on 5D	%	30 min.
Impact Energy CV @ as-welded	Joules	-

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	80	120	160	180	-	-
	<b>max.</b>	-	180	240	260	300	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	17	17	18	20	-	-
	<b>max.</b>	-	20	22	26	29	-	-

**Packaging Information**

<b>Kg Per Reel</b>	-	0.7/5/15	0.7/5/15	15	15	-	-
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**Storage****Storage**

It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.

**Gases****Gas MIG**CO<sub>2</sub> and Argon/CO<sub>2</sub> mixture**Gas TIG**

Argon

**Flow Rate**

12-16 l/min

**Flow Rate**

8-12 l/min

**Current Conditions DC+ and Welding Positions**