



# WB308LT T.I.G. WELDING WIRE

## Classifications

AWS A5.9-81 : ER308L

BSEN12072-00 : G19 9L

## Product Description

308L stainless steel, solid TIG wire.

## Applications

WB308LT 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
min.	-	1.0	0.30	-	-	19.5	9.0	-	-
max.	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
min.	-	-	-	-	80	80	80
max.	-	-	-	-	120	120	120
min.	-	-	-	-	-	-	-
max.	-	-	-	-	-	-	-

## Packaging Information

### Kg Per Tube

-	-	-	-	5	5	5
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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

Pure Argon

### Flow Rate

7-10 l/min

## Current Conditions DC- and Welding Positions

