WB308LT TIG WELDING WIRE

Classifications	**AWS A5.9:** ER308L **BS EN ISO 14343-A:** W 19 9 L
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, values and general stainless-steel engineering. Ferrite in the 3-16 FN range.

Wire Composition (Wt. %)

	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/mm²	510 min.
Yield Stress/0.2% Proof Stress	N/mm²	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
Current Range (Amps)	**min.**	-	-	-	-	80	80	80
	max.	-	-	-	-	120	120	120
Volt Range (Volts)	**min.**	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
Packaging Information **Kg Per Tube**		-	-	-	-	5	5	5

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
12-14 l/min

Current Conditions DC- and Welding Positions