

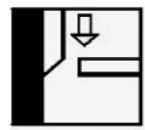
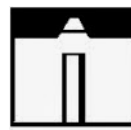
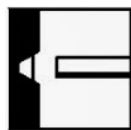
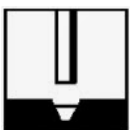


WB308LM MIG WELDING WIRE

Classifications	AWS A5.9: ER308LSi BS EN ISO 14343-A: G 19 9 LSi									
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 (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.		-	1.0	0.30	-	-	19.5	9.0	-	-
max.		0.03	2.5	0.80	0.03	0.03	22.0	11.0	0.5	0.50
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		510 min. *597					
	Yield Stress/0.2% Proof Stress		N/mm ²		320 min. *428					
	Elongation on 5D		%		30 min. *39					
	Impact Energy CV @ -196		Joules		*78					
	As welded				*actual					

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	260	340	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	23	26	29	-	-
Packaging Information								
Kg Per Reel		-	15	15	15	15	-	-
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 Argon + 2%O ₂ or Argon + 2-3%CO ₂				Flow Rate 15-20 L/min			

Current Conditions DC+ and Welding Positions



Approvals: CE