



S. R. Industries

STAR ARC ER308/308L

ER308/308L is used for welding types 304, 304L, 308, and 308L stainless steels. It is very similar to type 308, but has a carbon content held to a max of .03% to avoid carbide precipitation. This product can also be used for welding types 321 and 347 stainless steels. This wire is suitable for applications at cryogenic temperatures.

AWS Specification AWS A5.9/A5.9M:2006 :

AWS Classification	ER308
	ER308L
Welding Current	DCEP
Typical Wire Chemistry	
C	0.08
Cr	19.5 - 22.0
Ni	9.0 - 11.0
Mo	0.75
Mn	1.0 - 2.5
Si	0.30 - 0.65
P	0.03
S	0.03
Cu	0.75
Typical Mechanical Properties (As Welded)	
Yield Strength, ksi	59

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<i>Tensile Strength, ksi</i>	<i>88</i>
<i>Elongation%, min</i>	<i>39</i>
<i>Welding Positions</i>	<i>F,V,OH,H</i>

Available Diameters MIG with Operating Range in Amps :

<i>.023"</i>	<i>35-70</i>
<i>.030"</i>	<i>50-100</i>
<i>.035"</i>	<i>160-210</i>
<i>.045"</i>	<i>180-250</i>

Available Diameters TIG with Operating Range in Amps :

<i>.035"</i>	<i>60 - 90</i>
<i>.045"</i>	<i>80 - 110</i>
<i>1/16"</i>	<i>90 - 130</i>
<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>
<i>5/32"</i>	<i>170 - 350</i>

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