



# CEWELD 308L Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         |                      |                    |                         |        |          |
|---------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
| TYPE                                              | Stainless steel Tig filler metal for welding CrNi 18/10 types.( Type 308L, 19 9 L)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                         |                      |                    |                         |        |          |
| APPLICATIONS                                      | Boilers, agriculture, liquid storage tanks, food machinery, furniture.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                         |                      |                    |                         |        |          |
| PROPERTIES                                        | CEWELD® 308L Tig has good general corrosion resistance. The alloy has a low carbon content, making it particularly recommended where there is a risk of intergranular corrosion.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                         |                      |                    |                         |        |          |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | A 5.9: ER308L           |                      |                    |                         |        |          |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 14343-A: W 19 9 L       |                      |                    |                         |        |          |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 1.4316                  |                      |                    |                         |        |          |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 6                       |                      |                    |                         |        |          |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 5                       |                      |                    |                         |        |          |
| SUITABLE FOR                                      | <b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9%Ni , TÜV 1000: Gr. 21 - 22 (29 max.350°C),</b><br>1.4301, 1.4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.4316, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4546, 1.4550<br>X 5 CrNi 18 10, X 2 CrNi 19 11, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10<br>AISI 304, 304H, 312, 321H, 347, 347H,<br>UNS S30409, S32109, S34709, S30400, S32100, S34700                                                                                                                                                                                                                                |                         |                      |                    |                         |        |          |
| APPROVALS                                         | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                         |                      |                    |                         |        |          |
| WELDING POSITIONS                                 | <div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PE</div> <div> PF</div> <div> PG</div> |                         |                      |                    |                         |        |          |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Si                      | Mn                   | P                  | S                       | Cr     | Ni       |
|                                                   | 0.02                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.5                     | 1.5                  | 0.015              | 0.015                   | 20     | 10       |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         |                      |                    | RT                      | -196°C |          |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 420                     | 595                  | 37                 | 120                     | 47     | HRc      |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |                    |                         |        |          |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                         |                      |                    |                         |        |          |



# CEWELD 308L Tig

308L TIG 1,2 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663412348 |

308L TIG 1,6 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663412355 |

308L TIG 2,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663412362 |

308L TIG 2,4 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663412379 |

308L TIG 3,2 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663412386 |