



Changzhou Giant Welding Co.,Ltd
www.giantweld.com

Standard: AWS A 5.9 YB/T5092	Chemical Composition %								
	C	Mn	Si	Cr	Ni	P	S	Mo	Cu
Grade ER308L	≤0.03	1.0 – 2.5	0.3 – 0.65	19.5 – 22	9 – 11	≤0.03	≤0.03	≤0.75	≤0.75
Type	Spool (MIG)				Tube (TIG)				
Specification (MM)	0.8、 0.9、 1.0、 1.2、 1.6、 2.0				1.6、 2.0、 2.4、 3.2、 4.0、 5.0				
Package	S100/1kg S200/5kg S270,S300/15kg-20kg				5kg/box	10kg/box	length :1000MM		
Mechanical Properties	Tensile Strength Mpa				Elongation after fracture A (%)				
	≥ 520				≥ 35				
Diameter (MM)	0.8	1.0	1.2	1.6	2.0	2.5	3.2		
Current (A)	70 ~ 150	100 ~ 200	140 ~ 220	50 ~ 100	100 ~ 200	200 ~ 300	300 ~ 400		
Application	ER308L welding wire is also called H03Cr21Ni10Si. it is a welding wire for ultra-low carbon stainless steel. The welding process is excellent and the weld metal is of ultra-low carbon type, which reduces the precipitation of intergranular carbides. The intergranular corrosion resistance is excellent.								
	Used for welding ultra-low carbon 00Cr19Ni10 stainless steel structures or corrosion resistance below 300 °C steel 0Cr18Ni10Ti. Mainly used for synthetic fiber, welding 18Cr-8Ni stainless steel, arc stable, due to the increase of Si content, welding operation and fluidity better.								
Notice	1. Oil, dirt and rust on the welding wire surface should be removed before welding. Surface impurities such as oil, rust and water should be thoroughly removed in the welding place, so as to prevent blowhole, crack and so on during welding. The surface of the groove and its surroundings should be polished with metallic gloss.								
	2. In order to obtain good mechanical properties of welding seam, suggest protect gas Ar+2%O2 and shield gas flow rate 20-25 L/min for MIG welding. For TIG welding,suggest protect gas pure Ar and shield gas flow rate 8-15 L/min ,Arc length 1~3 mm; Length of the tungsten pole is about 3~5 mm; wind speed limit ≤ 1.0 m/s, argon protection at the back of welding area .								
	3. In the welding process, the welding line energy directly affects the mechanical properties and crack resistance of weld metal, and should be paid more attention to.								
	4. The above welding methods, conditions and specifications are for reference only. Users should evaluate the welding process according to their own welding characteristics before using the welding wire for the formal product welding.								

