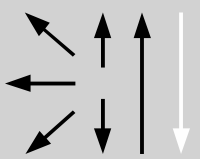


Classifications					
<b>EN ISO 14343-A</b>	<b>EN ISO 14343-B</b>			<b>AWS A5.9</b>	
W 19 9 L	SS308L			ER308L	
Characteristics and typical fields of application					
GTAW rod of type W 19 9 L / ER308L suitable not only for standard welding jobs but also for cryogenic applications down to -269°C.					
Good welding and wetting characteristics of BÖHLER EAS 2-IG as well as corrosion resistance up to +350°C is achieved.					
Base materials					
1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2CrNi18-10, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10 AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 Gr. C9; A320 Gr. B8C or D					
Typical analysis of the TIG rods (wt.-%)					
	C	Si	Mn	Cr	Ni
wt.-%	≤0.02	0.45	1.8	20.0	10.0
Mechanical properties of all-weld metal					
Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	
	MPa	MPa	%	+20°C	-269°C
u	<b>400</b> (≥ 320)	<b>550</b> (≥ 510)	<b>38</b> (≥ 25)	<b>150</b>	<b>75</b> (≥ 32)
u untreated, as welded – shielding gas Argon					
Operating data					
	<b>Polarity:</b> DC (–)	<b>Shielding gas:</b> 100% Argon	<b>Rod marking:</b> front: ✦ W 19 9 L back: ER 308 L	<b>ø (mm)</b>	
				1.6	
				2.0	
				2.4	
				3.0	
Approvals					
TÜV (00145.), DB (43.014.08), DNV (308L), GL (4550), SEPROZ, NAKS (Ø2.4;3.2), CE					

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