

### Standards

TS EN ISO 14343-A	: W 19 9 L
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AWS A5.9	: ER 308 L

### Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni
0.02	0.5	1.7	20.1	9.8

### Mechanical Properties

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))
min. 390	540 - 660	min. 63 J	min. 35

### Typical Base Material Grades

- X2CrNi 19 11, X5CrNi 18 10, X6CrNiTi 18 10, X6CrNiNb 18 10, X2CrNiN 18 10, X10CrNiNb 18 10
- AISI & ASTM: 304, 304L, 304LN, 347, 321, A320Gr.B8C, A320Gr.B8D

### Features and Applications

- TIG welding of 13% Cr ferritic stainless steels, high-carbon steels of type 304, or stabilized steels of type 347, or steels of similar qualities, all of which used in drug, cellulose, paper and food (production) industries
- The shielding gas is Argon (Ar).
- Maintenance of ductile behavior at temperature values down to -196°C
- Maintenance of resistance against intergranular corrosion at temperatures up to 400°C

### Welding Positions



### Current Type

TIG D.C.(-)

### Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6011100424	1.00 x 1000	0.040" x 39"	5	Plastic Box
6011100321	1.20 x 1000	0.047" x 39"	5	Plastic Box
6011100326	1.6 x 1000	1/16 x 39"	5	Plastic Box
6011100327	2.0 x 1000	5/64 x 39"	5	Plastic Box
6011100328	2.4 x 1000	3/32 x 39"	5	Plastic Box
6011100329	3.2 x 1000	1/8 x 39"	5	Plastic Box

Approvals: CE, SEPRO