



AMA 30-11 M

Standards: AWS/ASME SFA-5.9

ER 308 L

Application/ Properties: Austenitic stainless wire electrode in extra low carbon quantity for MIG/ MAG welding of unstabilized corrosion resistant Cr Ni steels. Resistant to intergranular corrosion up to 350 C, non-scaling up to 800 C if subjected to air or oxidizing combustion gases

Analysis of Wire electrode% (Typical value) :

C	Si	Cr	Mn	Ni
<0.03	0.3-0.65	19.5-22	1-2.5	9-11

Shielding gas: DIN EN 439 -M13 (0 -3% O₂, Balance Ar)

DIN EN 439 -M12 (0 -5% CO₂, Balance Ar)

Mechanical properties of all -weld metal :

Tensile Strength (N/mm ²)	0.2% Proof Stress (N/mm ²)	Elongation Lo = 4d %	Impact energy (j) ISO - V 25 °C
>520	>320	>35	>80

Material:

DIN EN standard 1.4306 X2CrNi19 11 G-X2CrNiN 18 9 ; 1.4301 X5CrNi18 10 ; 1.4311 X2CrNiN18 10 ; 1.4312 G-X10CrNi 18 8 ; 1.4541 X6CrNiTi18-10 ; 1.4546 X5CrNiNb18-10 ; 1.4550 X6CrNiNb18 10 ; 1.4303 X4CrNi18 12 ; 1.4306 X2CrNi19 11 ; 1.4308 G-X6CrNi18 9 ; 1.4310 X12CrNi17 7 ; 1.4319 X5CrNi18 7

other Standard AISI 304, 304L, 304LN, 302, 321, 347 ; ASTM A157 Gr. C9 ; A320 Gr. B8C

Delivery: Only wound wire - reel on:

weight :15kg.

diameter : 0.8 -1.6 mm

Note: other weight & sizes are produced upon customers request.

