

**MIDALLOY ER308L BARE WIRE**

**CLASSIFICATION**

- AWS 5.9 Class ER308L / ASME SFA 5.9 Class ER308L
- UNS# S30880 A#8 F#6

**DESCRIPTION**

- MIDALLOY ER308L stainless steel wire is used for GMAW, GTAW and SAW welding.

**APPLICATIONS**

- MIDALLOY ER308L is used to weld metals with similar composition; such as 304L (UNS S30403), in wrought and cast forms. This product is melted to reduce levels of carbon, phosphorus, and sulfur to reduce micro-fissuring.

**TYPICAL CHEMISTRY**

C	Si	Cr	Mn	P	Cu	S	N	Mo	Ni
.015	.48	20	1.85	.015	<.20	.010	.06	<.50	10.1

**TYPICAL MECHANICAL PROPERTIES**

TENSILE STRENGTH	83,500 PSI
YIELD STRENGTH	56,000 PSI
ELONGATION IN 2"	40%
CHARPY IMPACT @-320° F	45 FT-LBS

**RECOMMENDED WELDING PARAMETERS**

PROCESS	DIAMETER	VOLTAGE	AMPERAGE	GAS/FLUX*
TIG (GTAW)	1/16"	14-18	90-130	100% Ar
	3/32"	15-20	120-175	100% Ar
	1/8"	15-20	150-220	100% Ar
MIG (GMAW)	.035" SHORT ARC	16-26	70-160	69%Ar-30%He-1%O <sub>2</sub>
	.035" SPRAY ARC	26-31	150-230	92%Ar-8%Co <sub>2</sub> or
	.045" SPRAY ARC	28-32	180-280	98%Ar-2%O <sub>2</sub>
SUB ARC (SAW)	3/32"	28-30	275-350	Record IN or
	1/8"	29-32	350-450	Record IND 24

**PACKAGING**

- TIG 10 lb. tube/60 lb. carton
- MIG 30 lb. spool
- SUB-ARC 60 lb. coil

10/8/09

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