TIG 20/10

Old reference: TIG 308L

Classification

ISO 14343-A : W 19 9 L
AWS A5.9 : ER308L

Material.N° : 1.4316

Description & Applications

Solid low carbon rod for TIG welding of stainless steels (304L, 304, 347, 321…). The TIG process is particularly suited for welding of piping systems, works of fine thinness equal or inferior than 3 mm and for penetration passes.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	P	S	Fe
0.015	0.42	1.8	19.5	9.8	<0.02	<0.015	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
430	600	38	+20°C 150
			-196°C 50

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

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