



UP 308L

Classification

AWS A5.9 : ER308L

ISO 14343-A : S 19 9 L

Description & Applications

Low carbon solid wire for submerged arc welding for 304 and 304L grade stainless steel. Also used for stainless steels stabilised with niobium like 347 grade or stabilised with Titanium like 321 grade. For applications with service temperature between -120°C to +350°C.

Main applications: Boiler making, piping system, boilers...

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088	Material N°
S30400	304	X5CrNi18-10	1.4301
S30403	304L	X2CrNi19-11	1.4306
S32100	321	X6CrNiTi18-10	1.4541
S34700	347	X6CrNiNb18-10	1.4550

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Co	N	Fe
Min		0.30	1.0	19.5	9.0								
Max	0.03	0.65	2.5	21.0	11.0	0.5	0.5	-	0.03	0.02	-	-	Rem.
Type	0.015	0.40	1.8	19.7	9.8	0.10	0.10	0.01	0.02	0.015	0.05	0.06	Rem.

Delong Ferrite: 6-12%

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters				Flux
		Current (A)	Voltage (V)	Stick out (mm)	Speed (cm/min)	
SAW =+	2.4 3.2	200 - 400 300 - 500	25 - 30 28 - 32	18 - 25 20 - 30	40 - 60 40 - 60	WP380 WP380M