



PRODUCT DATA

Classification: AWS / ASME – A/ SFA 5.9 ER 308L
BS EN 14343: 2007 – W19.9. L

Approvals : TUV , DB,CE Marking

Typical Applications:

VENUS 308L is primarily used for welding austenitic stainless steel of type 304L/1.4306, 304/1.4301 type. This grade can be used to weld stabilized stainless steel grades like 347,321 for low service temperatures. . However it is recommended to use Venus 347Si for service temperature above 350°C. the higher silicon content gives better arc stability and weld fluidity..

Wire Composition: (%)

	C	Mn	Si	Cr	Ni	S	P	Mo
min	-	1.0	0.30	19.5	9	-	-	
max	0.03	2.5	0.65	21.0	11	0.03	0.03	0.30

Mechanical properties (Typical as Weld):

Tensile Strength	600N/mm ²
Yield Strength	400 N/mm ²
Elongation A5	35%
Impact energy(20° C)	120J
-196°C	50 J
Hardness	190 BHN

Ferrite content:

Ferrite Number about 9 – WRC-92

Welding Parameters

The information will be provided on request.

Shielding Gas:

I1 Pure Argon 5-10 L/min
M13 Argon+1-3% O₂ 5, 5-10 L/min

Corrosion resistance:

Good resistance to general and intergranular corrosion

Packaging Detail:

Diameter : 0.80,1.00,1.20,1.60, 2.0, 2.40, 3.20, 4.0 mm*

Length : 1000 mm (36")

Packing : 5 Kgs in Spiral Tubes/Plastic, then in a Master Carton of 25 Kg(5x5)**

Also available in AWS standard diameters

* *Available in Bulk packing /Customized packing /Neutral packing on request.

Marking:

Both ends embossed with grade and diameter for the diameter >=1.60mm



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