

TECHNICAL **DATA SHEET**



OK Tig Rods (GTAW) 308L Stainless Steel Rods

Art. No. 984.1610...

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PRODUCT DESCRIPTION

OK Tigrod 308L has a good general corrosion resistance. The alloy has a low carbon content which makes this alloy particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food processing industries as well as for pipes, tubes and boilers. For joining of stainless steels of 18%Cr - 8% Ni-type with low carbon content and Nb-stabilized steels of the same type if the service temperature will not exceed 350°C. Can also be used for welding of Cr-steels except in sulphur rich environments.

Classifications Wire Electrode	SFA/AWS A5.9 : ER308L EN ISO 14343-A : W 19 9 L Werkstoffnummer : 1.4316
Approvals	CE EN 13479 CWB ER308L DNV-GL VL 308 L NAKS/HAKC 1.6-2.4 mm VdTÜV 04269

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C
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Typical Tensile Properties

Yield Strength	Tensile Strength	Elongation
480 MPa (70 ksi)	610 MPa (88.5 ksi)	36 %

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
20 °C (68 °F)	170 J (125 ft-lb)
-80 °C (-112 °F)	135 J (99.5 ft-lb)
-196 °C (-321 °F)	80 J (59 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.01	1.8	0.4	0.015	0.020	10	20	0.1	0.1

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	N	FN WRC-92
0.02	1.9	0.4	9.8	19.8	0.20	0.15	0.05	9

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2021

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