THS-308L (ER308L)

STAINLESS STEEL MIG WELDING WIRE

AWS A5.9 ER308L
NB/T 47018 S308L
GB/T 29713 S308L
YB/H022Cr21Ni10

APPLICATION

Welding 00Cr19Ni10 (SUS304L) and similar materials in petrochemical equipment, food-processing machinery, and medical equipment.

CHARACTERISTICS

THS-308L is an extra-low-carbon 21% Cr-10% Ni austenitic stainless steel filler wire with a stable arc, good bead appearance, and all-position welding capability. It offers good resistance to intergranular corrosion.

PRECAUTIONS

Remove rust, oil, moisture, and other contaminants from the workpiece before welding. Use Ar + 1-3% O_2 shielding gas for MIG welding. Establish a suitable welding procedure for the actual production conditions.

WELDING POSITIONS



MECHANICAL PROPERTIES

Items	Tensile strength (MPa)	Elongation (%)
Typical results	590	40

WIRE CHEMICAL COMPOSITION (%)

Items	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
Requirements	≤0.030	1.00-2.50	0.30-0.65	19.50-22.00	9.00-11.00	≤0.75	≤0.025	≤0.020	≤0.75
Typical results	0.020	1.95	0.54	21.00	10.40	0.05	0.021	0.013	0.04