

TECHNICAL DATASHEET - WELDING CONSUMABLE

AWS Code:	-
Product Code:	RW 308L
Werkstoff No.:	-
MIG Certification:	CE - CWB
TIG Certification:	TUV (1,6-4,0 mm) - CE - CWB

EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition 19 9 L	AWS A5.9:2017 Alloy Designation -	EN ISO 14343-B:2017 Alloy Type -	AWS A5.9:2017 Composition Designation -

DESCRIPTION AND APPLICATIONS

RW 308L / RW 308LAWS / RW 19-9-L / RW 308LSI / RW 308H is a stainless welding wire class for austenitic stainless steels. RW 308L, RW 308LAWS and RW 19-9-L support corrosion resistance by reducing chromium carbide precipitation at grain boundaries. RW 308LSI uses higher Si to improve arc stability, penetration, fluidity and bead appearance. RW 308H targets high-temperature use with improved creep strength from higher carbon content.

EXPECTED MINIMUM MECHANICAL PROPERTIES AS WELDED

	MIG	TIG	SAW
Rp0,2 [MPa]	390	465	400
Rp1 [MPa]	415	490	550
Rm [MPa]	570	630	35
A [%]	35	35	65
Z [%]	40	60	-
Impact Energy, ISO-V 20°C	140	261	-
Impact Energy, ISO-V -20°C	-	-	-
Impact Energy, ISO-V -60°C	-	-	-
Impact Energy, ISO-V -110°C	84	162	-
Impact Energy, ISO-V -120°C	-	-	-
Impact Energy, ISO-V -196°C	52	59	-

DIAMETER

MIG sizes	0,8 0,9 1,0 1,14 1,2 1,6
TIG sizes	0,8 0,9 1,0 1,2 1,6 2,0 2,4 3,2 4,0
SAW sizes	1,6 2,0 2,4 3,2 4,0

TYPICAL CHEMICAL COMPOSITION (%)

	Min.	Max.
C	-	0,03
Mn	1,00	2,50
Si	-	0,20
S	-	0,020
P	-	0,030
Cr	19,5	21,0
Ni	9,0	11,0
Mo	-	0,30
Cu	-	0,30
N	-	-
Nb	-	-
Ti	-	-

PACKAGING

MIG	Blue Metallic Wire Basket BS300: 15 Kg. Plastic Spool D300: 15 Kg. Plastic Spool D200: 5 Kg. Wooden/Metallic Bulk Spool: 250 Kg. Drum: 250-400 Kg.
TIG	Carton Boxes/Tubes: 5 Kg. (1000 mm Rod Length)
SAW	Metallic Wire Basket K415 Wooden/Metallic Bulk Spool: 250 Kg. Drum: 300 Kg.

Note: Safety Data Sheet is available on request.

TECHNICAL DATASHEET - WELDING CONSUMABLE

AWS Code:	ER308LSi
Product Code:	RW 308LSI
Werkstoff No.:	1.4316
MIG Certification:	TUV (0,8-1,6 mm) - CE - UKCA - DB - CWB
TIG Certification:	TUV (1,6-4,0 mm) - CE - UKCA - DB - CWB

EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
19 9 L Si	ER308LSi	SS308LSi	ER308LSi

DESCRIPTION AND APPLICATIONS

RW 308L / RW 308LAWS / RW 19-9-L / RW 308LSI / RW 308H is a stainless welding wire class for austenitic stainless steels. RW 308L, RW 308LAWS and RW 19-9-L support corrosion resistance by reducing chromium carbide precipitation at grain boundaries. RW 308LSI uses higher Si to improve arc stability, penetration, fluidity and bead appearance. RW 308H targets high-temperature use with improved creep strength from higher carbon content.

EXPECTED MINIMUM MECHANICAL PROPERTIES AS WELDED

	MIG	TIG	SAW
Rp0,2 [MPa]	390	465	-
Rp1 [MPa]	415	490	-
Rm [MPa]	570	630	-
A [%]	35	35	-
Z [%]	40	60	-
Impact Energy, ISO-V 20°C	140	261	-
Impact Energy, ISO-V -20°C	-	-	-
Impact Energy, ISO-V -60°C	-	-	-
Impact Energy, ISO-V -110°C	84	162	-
Impact Energy, ISO-V -120°C	-	-	-
Impact Energy, ISO-V -196°C	52	59	-

DIAMETER

MIG sizes	0,8 0,9 1,0 1,14 1,2 1,6
TIG sizes	0,8 0,9 1,0 1,2 1,6 2,0 2,4 3,2 4,0
SAW sizes	1,6 2,0 2,4 3,2 4,0

TYPICAL CHEMICAL COMPOSITION (%)

	Min.	Max.
C	-	0,03
Mn	1,00	2,50
Si	0,65	1,00
S	-	0,020
P	-	0,030
Cr	19,5	21,0
Ni	9,0	11,0
Mo	-	0,30
Cu	-	0,30
N	-	-
Nb	-	-
Ti	-	-

PACKAGING

MIG	Blue Metallic Wire Basket BS300: 15 Kg. Plastic Spool D300: 15 Kg. Plastic Spool D200: 5 Kg. Wooden/Metallic Bulk Spool: 250 Kg. Drum: 250-400 Kg.
TIG	Carton Boxes/Tubes: 5 Kg. (1000 mm Rod Length)
SAW	Metallic Wire Basket K415 Wooden/Metallic Bulk Spool: 250 Kg. Drum: 300 Kg.

Note: Safety Data Sheet is available on request.

TECHNICAL DATASHEET - WELDING CONSUMABLE

AWS Code:	ER308H
Product Code:	RW 308H
Werkstoff No.:	-
MIG Certification:	-
TIG Certification:	-

EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
19 9 H	ER308H	SS308H	ER308H

DESCRIPTION AND APPLICATIONS

RW 308L / RW 308LAWS / RW 19-9-L / RW 308LSI / RW 308H is a stainless welding wire class for austenitic stainless steels. RW 308L, RW 308LAWS and RW 19-9-L support corrosion resistance by reducing chromium carbide precipitation at grain boundaries. RW 308LSI uses higher Si to improve arc stability, penetration, fluidity and bead appearance. RW 308H targets high-temperature use with improved creep strength from higher carbon content.

TYPICAL CHEMICAL COMPOSITION (%)

	Min.	Max.
C	0,04	0,08
Mn	1,00	2,50
Si	0,30	0,65
S	-	0,020
P	-	0,030
Cr	19,5	21,0
Ni	9,0	11,0
Mo	-	0,30
Cu	-	0,30
N	-	-
Nb	-	-
Ti	-	-

DIAMETER

MIG sizes	0,8 0,9 1,0 1,14 1,2 1,6
TIG sizes	0,8 0,9 1,0 1,2 1,6 2,0 2,4 3,2 4,0
SAW sizes	1,6 2,0 2,4 3,2 4,0

PACKAGING

MIG	Blue Metallic Wire Basket BS300: 15 Kg. Plastic Spool D300: 15 Kg. Plastic Spool D200: 5 Kg. Wooden/Metallic Bulk Spool: 250 Kg. Drum: 250-400 Kg.
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SAW	Metallic Wire Basket K415 Wooden/Metallic Bulk Spool: 250 Kg. Drum: 300 Kg.

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