

Solid Wire Electrode for MIG/MAG Welding

BA-MIG 308L

Classification: EN ISO 14343-A: **G 19 9 L**
SFA-5.9: **ER308L**

Main Application:

BA-MIG 308L is a solid wire electrode for GMAW of 18% Cr – 10% Ni, austenitic stainless steels 1.4301, 1.4306 type 304, 304L. Suitable for service temperature from -196 °C to +350 °C.

Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9:

(Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-MIG 308L	0.02	0.5	1.8	0.1	10.0	20.0	0.020	0.013	0.1
G 19 9 L acc. to ISO 14343-A	0.03	0.65	1.0-2.5	0.3	9.0-11.0	19.0- 21.0	0.03	0.02	0.3
ER308L acc. to AWS A5.9	0.03	0.30- 0.65	1.0-2.5	0.75	9.0-11.0	19.5- 22.0	0.03	0.03	0.75

Also available BA-MIG 308LF with low ferrite content.

All - Weld Metal Mechanical Properties / Welding Data:

Heat Treatment	As Welded
Yield Strength Re, N/mm ² (ksi)	320 (46)
Tensile Strength Rm, N/mm ² (ksi)	550 - 650 (80-94)
Elongation A5 [%]	>30
Impact Energy ISO-V, J (ft lbs)	+20°C: 120 (88)
Current/polarity	DC +
Shielding Gas	ISO 14175: M12/M13

Base Materials:

1.4306/X2CrNi19-11, 1.4301/X5CrNi18-10, 1.4311/ X2CrNi18-10, 1.4312/ GX10CrNi18-8, 1.4541/ X6CrNiTi18-10, 1.4546/ X5CrNiNb18-10, 1.4550/ X6CrNiNb18-10 AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 Gr. C9; A320 Gr. B8C or D.

Package Forms:

Spools BS300/15 kg, D200/5 kg, and drums as standard package forms for GMAW wire electrodes.

Diameter:

0,8 – 1,6 mm. Sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire Electrode Surface:

Smooth finish free from surface defects and foreign matter.