

Solid Wire Electrode for Submerged Arc Welding

BA-WIRE 308L

Classification: EN ISO 14343-A – S 19 9 L
SFA-5.9 / AWS A5.9 – ER308L

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-WIRE 308L	0.02	0.4	1.8	0.1	10.0	20.0	0.020	0.013	0.1
S 19 9 L acc. to ISO 14343-A	0.03	0.65	1.0–2.5	0.5	9.0–11.0	19.0–21.0	0.03	0.02	0.5
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-W308LF with low ferrite content.

Application:

BA-WIRE 308L is a submerged arc welding wire intended for welding 18% Cr – 10% Ni austenitic stainless steels 1.4306 type 304, 304L. Suitable for service temperatures from –196 °C to +350 °C.

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 grade C9; A320 grade B8C or D
Suitable fluxes: BF 38, WP 380

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package forms:

Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

Diameter:

1.6 – 4.0 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire electrode surface:

Smooth finish free from surface defects and foreign matter.