

INERTROD 308L is a W 19 9 L/ER 308L type solid TIG welding rod depositing a low C-19Cr 9 Ni weld metal. Suitable for use mainly with Ar shielding gas.

INERTROD 308L is used for the welding of 304 and 304L grade stainless steel. The weld metal has good corrosion resistance properties, including intergranular attack from a range of liquid media at service temperatures <300°C. It is used for a wide range of applications including pipework and plate fabrication, vessel production etc. Batch with controlled low ferrite number is available for cryogenic applications.

Low carbon reduces the propensity to intergranular carbide precipitation, which increases the resistance to intergranular corrosion without the use of stabilizers.

Classification		Approvals	Grade
EN ISO	14343-A: W 19 9 L	DB	●
AWS	A5.9: ER 308L	TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni
0.020	1.8	0.45	≤ 0.025	≤ 0.020	20	10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-196 °C
As Welded	≥ 350	≥ 520	≥ 35	≥ 140	≥ 40

Gas test: 100% Ar

Shielding Gas - EN ISO 14175 : I1

Materials

AISI 304 - 304L - 302

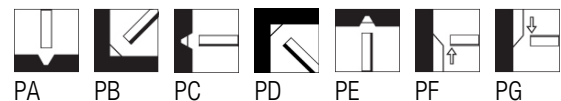
1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4311 (X2CrNiN18-10)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
2.0	TUB	5	●
2.4	TUB	5	●