


GMAW / GTAW STAINLESS STEEL
MIGINOX 308L / TIGINOX 308L

EXTRA LOW CARBON AUSTENITIC STAINLESS STEEL SOLID WIRE FOR SS 304 WELDING


CLASSIFICATION : EN ISO 14343-A

AWS A/SFA 5.9

APPROVALS :

Miginox 308L: G 19 9 L

ER308L

RDSO (Class VI)

Tiginox 308L: W 19 9 L

ER308L

NPCIL

KEY FEATURES :

- An extra low carbon 308L type stainless steel solid wire
- Excellent crack resistance
- Excellent corrosion & scaling resistance up to 800°C
- Resistance to intergranular corrosion
- Radiographic quality welds

WELDING POSITION :

GMAW: DCEP
GTAW: DCEN

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
GMAW: 98Ar/2O ₂ or Ar/1-5CO ₂	15-22	10-20
GTAW: Ar	10-15	-

TYPICAL APPLICATIONS :

- Welding Cr-Ni steels represented by AISI 301, 302, 304, 304L, 308, 308L
- SS piping in refineries, oil and gas industries, chemical plants, food processing industries
- Fabrication of boilers, reactors, turbines, pipes, tubes

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.03 max	1.0-2.5	0.30-0.65	19.5-22.0	9.0-11.0	0.75 max	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	520 min	35 min

Mechanical properties will vary with the type of shielding gas used.

SPECIAL TEST : IGC practice E as per ASTM A262

PACKING DATA :

Miginox 308L	Ø, mm		Kg/Spool	
	0.8		12.5	
	1.2		12.5	
	1.6		12.5	
	2.0		12.5	
Tiginox 308L	Ø x L, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
	1.6 x 1000	5	4	20
	2.0 x 1000	5	4	20
	2.5 x 1000	5	4	20

EQUIVALENT :

 SMAW Electrode: **Superinox 1C**

 FCAW Wire: **Miginox FC 308L**