



M-90 ER308L

FEATURES

- *RESISTANCE TO CRACK
- *HIGH EFFICIENCY
- *RESISTANCE TO CORROSION

APPLICATION

*Designed for welding root passes in grooves with root opening. High corrosion resistance in oxidizing environments.

CLASSIFICATION

*AWS/A5.9/ ASME SFA5.9
ER308L

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.02	0.32	1.70			20.0	10.1	

MECHANICAL PROPERTIES

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm2 (lbs/in 2)	N/mm2 (lbs/in 2)	(%)	oC (oF)	J (ft lbs)
	600 (87,000)	41	0 (32)	110(81)

WELDING PARAMETERS

DIAMETER (mm)	1.6	2.4
LENGTH (mm)	1000	1000
CURRENT (amps)		

CURRENT

*DC -

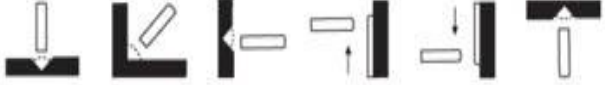
GAS

Ar

WELDING POSITIONS

Current

= +	~	(U ₀ : 50V)
-----	---	------------------------



ASME:	1G	2F	2G	3G	3G	4G
ISO 6947	PA	PB	PC	PF	PG	PE
