

AI-0208T

Specifications

AS/NZS 1553.3:ER 308L-16

AWS/ASME A5.4 ER 308L-16 SME

Description and Applications

AI-0208T is suitable for welding steels containing 16-21% Cr, 8-13% Ni (Generally type 304 S/S) when easy welding and fine bead appearance are required.

Typical Weldmetal Analysis

C	Mn	Cr	Fe	Ni	Si
0.02	0.9	19.3	Bal	9.7	0.8

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	600MPa
Yield Strength (0.2%)	450Mpa
Elongation	45% (4d)
Recovery	160%
Charpy V	40J (-105°C) 30J (20°C)

Welding Instruction

Degrease and clean weld area thoroughly (metallic bright). Preheating and post heat treatment is usually not necessary.

Welding Parameters

Diameter (mm)	Current type	Shielding Gas
1.6 x 1000	DC (-)	I 1
2.4 x 1000	DC (-)	I 1
3.2 x 1000	DC (-)	I 1

Electrode: **AI-0208**

MIG wire: **AI-1708L, AI-1708H**

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au

