

Rods for stainless steel TIG - T08W

EN ISO 14343-A: W 19 9 LSI
DIN 8556 SG - X2 CRNI 19 9
AWS A-5.9: ER308LSI

These not coated rods are resistant to corrosion and are intended for welding using TIG method of austenitic chrome-nickel steel, type 18%Cr, 8%Ni. The weld metal features good resistance to general corrosion. Low carbon content makes them especially suitable in situations where the risk of intercrystalline corrosion occurs. Increased silicone content improves welding properties such as wetting properties. The weld metal is widely used in chemical and food industry as well as for welding of pipelines, pipes and boilers.

Approvals:

TÜV*

DB*

* Certificate is pending

Welded material:

AISI 304, 304L,
W. Nr: 1.4301; 1.4541; 1.4550 etc.

Shielding gas (EN ISO 14175):

l1

Welding current:

=(-)

Product no

ø mm	1,0	1,2	1,6	2,0	2,4	3,2	4,0
Code	T08W.064	T08W.065	T08W.066	T08W.067	T08W.068	T08W.069	T08W.070

Typical Chemical composition of the weld metal (%)

C	Si	Mn	Cr	Ni
<0,03	0,85	1,80	20,00	10,00

Typical mechanical properties of the weld metal

Test method	Condition	Gas	R _m MPa	R _{p0,2} MPa	A ₅ %	KV (J)/°C			
						+20	-60	-110	-196
EN	TZ0	l1	625	480	37	170	150	140	100

TZ0 - after welding