

CWR-308L Welding Wire and Rod

CWR-308L has the same chemical composition as CWR-308 except the carbon content has been held to .03% maximum to minimize the possibility of intergranular carbide precipitation. It is commonly used to weld stainless steel type 304L, 321 and 347. Depending on temperature range and flux selection, CWR-308L is a suitable welding wire for applications at cryogenic temperature.

CONFORMANCES

AWS A5.9/A5.9M	:	ER 308L
ASME SFA-A5.9	:	ER 308L
ISO 14343-B	:	SS 308L

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%Mn
0.03 max 0.014	19.5 – 22.0 19.8	9.0 – 11.0 10.0	0.75 max 0.17	1.0 – 2.5 1.8
%Si	%P	%S	%Cu	Total Others
0.30 – 0.65 0.39	0.03 max 0.02	0.03 max 0.01	0.75 max 0.13	0.50 max

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength	:	57,000 psi
Tensile Strength	:	87,000 psi
Elongation	:	35 %

TYPICAL WELDING PARAMETERS

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 18	80 – 150	100% Ar
	3/32"	2.4 mm	15 – 20	150 – 250	100% Ar
	1/8"	3.2 mm	16 – 20	200 – 375	100% Ar
MIG (GMAW)	.035"	0.9 mm	23 – 29	170 – 290	98%Ar – 2%O ₂
	.045"	1.1 mm	24 – 30	200 – 360	98%Ar – 2%O ₂
Sub Arc (SAW)	.093"	2.4 mm	28 – 32	250 – 450	
	.125"	3.2 mm	29 – 34	300 – 500	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED
BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

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