



**MANUFACTURERS OF A DIVERSE RANGE OF
ADVANCED WELDING CONSUMABLES**

**SECTION
13**

WI-0304 DS167 NSB-308LR, Rev. 1, Date 01.07.2013

NSB-308LR	FILLER ROD FOR WELDING LOW-CARBON AUSTENITIC STAINLESS STEELS CONTAINING A NOMINAL 19Cr-10Ni										DATA SHEET NO. 167		
											SPECIFICATION		
CLASSIFICATION			ER308L			Y308L			W 19 9 L				
WELD METAL ANALYSIS COMPOSITION % BY Wt.				C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Fe
MIN				-	19.5	9.0	-	1.0	0.3	-	-	-	
MAX				0.03	22	11	0.75	2.5	0.65	0.03	0.03	0.75	
TYPICAL				0.02	20	10	0.1	1.8	0.5	0.02	0.02	0.3	Bal.
WELD METAL PROPERTIES (ALL WELD METAL)			<u>PROPERTY</u>		<u>UNITS</u>		<u>MINIMUM</u>		<u>TYPICAL</u>		<u>OTHERS</u>		
			Tensile strength		N/mm ²		520		600				
			0.2% Proof stress		N/mm ²				460				
			Elongation on 4d		%		30		45				
			Impact energy -196 °C		J		-		80				
OTHER DATA			Argon mainly use as shielding gas										
RELATED PRODUCTS			Please contact our Technical Department for detail										