



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

**SECTION
13**

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

NSN-308LR	FILLER ROD FOR WELDING LOW-CARBON AUSTENITIC STAINLESS STEELS CONTAINING A NOMINAL 19Cr-10Ni					DATA SHEET NO. 167					
						SPECIFICATION	AWS A5.9	JIS Z 3321	BS EN 12072		
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 used as shielding gas										
RELATED PRODUCTS	Please contact our Technical Department for detail										

UNCONTROLLED