

Shield-Bright 308L

Shield-Bright 308L is a rutile cored wire designed for the all-positional welding of stainless steels excluding vertical down. In addition to the 304L and 308L grades it is also suitable for welding the stabilised 321 and 347 grades with Ar/15-25%CO₂ or CO₂ shielding gas.

Classifications Weld Metal:	SFA/AWS A5.22:E308LT1-4, SFA/AWS A5.22:E308LT1-1, JIS Z 3323:TS308L-FB1 , KS D 3612:YF 308LC, EN ISO 17633-A:T 19 9 L P C1 2 , EN ISO 17633-A:T 19 9 L P M21 2
Approvals:	CE EN 13479, ABS E308LT1-1 (C1), BV 308L (C1), CCS 308L (C1), ClassNK KW308LG(C) (C1), CWB E308LT1-1 (C1), CWB E308LT1-4 (M21), DNV NV 308L (C1), KR RW308LG (C) (C1), LR 304L (C1), VdTÜV 04832 (M20,M21)

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC+
Alloy Type:	Austenitic 308L

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 Shielding gas			
As welded	410 MPa	580 MPa	44 %

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
C1 shielding gas				
0.030	1.20	0.90	10.0	19.0

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	130-220 A	24-29 V	5.8-14.4 m/min	1.9-4.6 kg/h