

Product Data Sheet



BRAND NAME VJ ER308L

AWS/ASME Class ER308L

SPECIFICATION SFA A5.9

Features and Applications :

VJ ER308L is a solid wire with a bright finish, providing a smooth arc, stable flow, and spatter-free welding. It contains low-carbon 20Cr-10Ni, ensuring radiographic-quality welds and excellent resistance to intergranular corrosion. Suitable for welding 304L stainless steel and equivalents, as well as overlays, surfacing, and repairs.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.03	Mn	1.0-2.50
Cr	19.5-22.0	Si	0.30-0.65
Ni	9.0-11.0	S	0.03
Mo	0.75	P	0.03
Cu	0.75		

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	520 Min
El (%)	35 Min

DIMENSIONS:

Dimension (mm)	
GMAW	GTAW
0.80	1.6
1.20	2.0
1.60	2.4
	3.2

GMAW CURRENT : DC (+)	SHIELDING GAS: ARGON
GTAW CURRENT : DCEN	SHIELDING GAS: ARGON

PACKING :

GTAW : 5 kg wire put in a plastic container. Identification AWS code is punched on side of wire.

GMAW : The wire can be supplied in plastic spool packed in a cardboard box weighing 15.0 kg.

WELDING POSITION:

