



# OK Tigrod 308L

GTAW

Bare, corrosion-resistant, chromium-nickel TIG rod. OK Tigrod 308L has a good general corrosion resistance. The alloy has a low carbon content which makes it particularly recommended when there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries, as well as for pipes, tubes and boilers. Suitable for the joining of stainless steels of the 18%Cr-8%Ni type with a low carbon content and Nb-stabilised steels of the same type if the service temperature does not exceed 350°C. It can also be used for welding Cr steels, except in sulphur-rich environments.

## Welding Current

DC (-)

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Per Pack (kg)	Pallet Weight (kg)
161010R150	1.0	5	840
161012R150	1.2	5	840
161016R150	1.6	5	840
161020R150	2.0	5	840
161024R150	2.4	5	840
161032R150	3.2	5	840
161040R150	4.0	5	840

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
<u>SFA/AWS A5.9</u>	DNV 308L (-60°C)	C <0.03	<u>Yield Stress, Mpa</u>
ER308L	VdTÜV 0.4269	Si 0.5	450
<u>EN 12072</u>		Mn 1.8	<u>Tensile Strength, Mpa</u>
W 19 9 L		Cr 20.3	645
<u>Werstoffnummer</u>		Ni 10.0	<u>Elongation, %</u>
~1.4316		Mo <0.3	36
		Cu <0.3	<u>Charpy V</u>
			Test Temps, °C    Impact Values, J
			+20                    170
			-80                    135
			-196                   90

