

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 15% Ar - 25% CO₂ or CO₂ shielding gas.

Classifications Weld Metal	SFA/AWS A5.22 : E308LT1-4 SFA/AWS A5.22 : E308LT1-1 JIS Z 3323 : YF 308LC 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	ABS E308LT1-4 ABS E308LT1-1 BV 308L (C1) BV SA 308L (M21) CCS 308L (C1) CE EN 13479 ClassNK KW308LG(C) CWB E308LT1-1 (C1) CWB E308LT1-4 (M21) DNV-GL VL 308L (M21) KR RW308LG (C) (C1) LR 304L S (M21) C1) NAKS/HAKC 1.2MM VdTUV 04832 (M20 M21)

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

Welding Current	DC+
Alloy Type	C Cr Ni

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 Shielding Gas			
As Welded	410 MPa	580 MPa	44 %
C1 Shielding gas			
As Welded	372 MPa	568 MPa	61 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas		
As Welded	-29 °C	60 J
As Welded	-196 °C	30 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr
0.025	1.10	0.70	0.007	0.025	10.0	19.1

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