

## Shield-Bright 308L X-tra

FCAW wire for 18%Cr - 8%Ni stainless steel, For flat and horizontal position welding. Designed for welding types 301, 302, 304, 304L, 308, 308L steels. Ideal where service temperatures are below 500°F(260°C). Low carbon content helps minimize carbide precipitation. Carbon content 0.04% maximum.

| Specifications         |  |
|------------------------|--|
| <b>Classifications</b> | SFA/AWS A5.22 : E308LT0-1<br>SFA/AWS A5.22 : E308LT0-4<br>JIS Z 3323 : TS308L-FB0<br>KS D 3612 : YF308LC<br>EN ISO 17633-A : T 19 9 L R C1 3<br>EN ISO 17633-A : T 19 9 L R M21 3                      |
| <b>Approvals</b>       | ABS : E308LT0-1<br>BV : 308L (M21)<br>CE : EN 13479<br>CWB : E308LT0-1 (M21)<br>CWB : E308LT0-4 (C1)<br>DNV-GL : VL 308L (C1)<br>KR : RW308LG(C) (C1)<br>LR : 304L<br>UKCA : EN 13479<br>VdTÜV : 06611 |

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

|                        |                        |
|------------------------|------------------------|
| <b>Welding Current</b> | DC+                    |
| <b>Alloy Type</b>      | C Cr Ni                |
| <b>Shielding Gas</b>   | M21, C1 (EN ISO 14175) |

| Typical Tensile Properties |                |                  |            |
|----------------------------|----------------|------------------|------------|
| Condition                  | Yield Strength | Tensile Strength | Elongation |
| <b>M21 Shielding Gas</b>   |                |                  |            |
| As Welded                  | 410 MPa        | 580 MPa          | 40 %       |
| <b>C1 shielding gas</b>    |                |                  |            |
| As Welded                  | 409 MPa        | 549 MPa          | 55 %       |

| Typical Charpy V-Notch Properties |                     |              |
|-----------------------------------|---------------------|--------------|
| Condition                         | Testing Temperature | Impact Value |
| <b>M21 Shielding Gas</b>          |                     |              |
| As Welded                         | -29 °C              | 40 J         |
| As Welded                         | -196 °C             | 24 J         |

| Typical Weld Metal Analysis % |      |      |       |       |     |      |
|-------------------------------|------|------|-------|-------|-----|------|
| C                             | Mn   | Si   | S     | P     | Ni  | Cr   |
| <b>C1 shielding gas</b>       |      |      |       |       |     |      |
| 0.030                         | 1.30 | 0.48 | 0.004 | 0.020 | 9.8 | 19.4 |
| <b>M21 Shielding Gas</b>      |      |      |       |       |     |      |
| 0.022                         | 1.40 | 0.90 | 0.004 | 0.020 | 9.9 | 19.6 |

| Deposition Data |           |         |                 |                 |
|-----------------|-----------|---------|-----------------|-----------------|
| Diameter        | Current   | Voltage | Wire Feed Speed | Deposition Rate |
| 1.2 mm          | 150-250 A | 25-32 V | 8.0-16.0 m/min  | 2.5-7.0 kg/h    |
| 1.6 mm          | 200-350 A | 26-34 V | 4.0-11.0 m/min  | 3.0-7.5 kg/h    |