



HILCO HILCHROME W308L

TIG rods – stainless steel – acid resistant

AWS A5.9: ER 308L

EN ISO 14343-A: W 19 9 L

Werkstoffnr. 1.4316

Wire type:
TIG Solid wire

Current:



Welding positions:



Shielding gas:
I1

Hilchrome W308L is our solid wire for TIG welding low carbon 18Cr10Ni austenitic stainless steel grades like AISI 304, 304L. Typical applications include all industries where similar materials (incl. higher carbon types) as well as ferritic 13% Cr steels are used. Hilchrome W308L is also suitable for Nb (Cb) or Ti stabilised grades 347 and 321. Weld metal has an excellent resistance to general and intergranular corrosion (up to 350°C), good resistance to oxidising acids and cold reducing acids. To be used in combination with tungsten electrodes type WS2 WITSTAR®.

Base materials to be welded:

- ASTM/AISI Grade 302, 304, 304L, 304LN, 321, 347
- WNr 1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4300
- CrNi 18 10 and similar stainless steel grades

Applications:

- Shipbuilding & Offshore
- Power Generation
- General fabrication & construction
- Repair & Maintenance
- Process Industry

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	Cr	Ni
0,02	1,65	0,42	20,10	10,30

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 320	≥ 510	≥ 25	20°C ≥ 100 -196°C ≥ 35

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
1,6	1000	5
2,0	1000	5
2,4	1000	5
3,2	1000	5