

**Wire type:**

TIG Solid wire

**Current:**



**Welding positions:**



**Shielding gas:**

I1 = Pure Ar

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

**Equivalent product in alternative welding process:**

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
Hilchrome 308R	Hilchrome G308L Si	-	-	-	-

**Chemical composition, wt.% weld metal – typical:**

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,03	1,70	0,60			21,0	10,0					

**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	≥ 550	≥ 30	+20°C ≥ 80 -196°C ≥ 35

Note: properties under pure Argon gas shielding

**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