



## **M-90 ER308L**

### **FEATURES**

- \*RESISTANCE TO CRACK
- \*HIGH EFFICIENCY
- \*RESISTANCE TO CORROSION

### **APPLICATION**

\*Designed for welding root passes in grooves with root opening. High corrosion resistance in oxidizing environments.

### **CLASSIFICATION**

\*AWS/A5.9/ ASME SFA5.9  
ER308L

### **CHEMICAL COMPOSITIONS**

C	Si	Mn	P	S	CR	Ni	MO
0.02	0.32	1.70			20.0	10.1	

### **MECHANICAL PROPERTIES**

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm <sup>2</sup> (lbs/in <sup>2</sup> )	N/mm <sup>2</sup> (lbs/in <sup>2</sup> )	(%)	oC ( oF)	J (ft lbs)
	600 (87,000)	41	0 (32)	110(81)

### **WELDING PARAMETERS**

DIAMETER (mm)	1.6	2.4
LENGTH (mm)	1000	1000
CURRENT (amps)		

### **CURRENT**

\*DC -

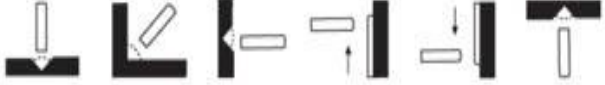
### **GAS**

Ar

# WELDING POSITIONS

*Current*

= +	~	(U <sub>0</sub> : 50V)
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ASME:	1G	2F	2G	3G	3G	4G
ISO 6947	PA	PB	PC	PF	PG	PE

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