

BLUE MAX[®] MIG 308LCF

Stainless ▪ AWS ER308L

KEY FEATURES

- Controlled Low Ferrite (Range 3-6 FN)
- Charpy V-Notch test results capable of exceeding 27 J (20 ft•lbf) @ -196°C (-320°F)
- Exceeds 15 mils (0.38 mm) of lateral expansion @ -196°C (-320°F)
- Q2 Lot[®] - Certificates showing actual wire chemistry available online

WELDING POSITIONS

All

SHIELDING GAS

98% Argon / 2% Oxygen

CONFORMANCES

AWS A5: ER308, ER308L

TYPICAL APPLICATIONS

- LNG Storage
- Cryogenic Vessels and Piping

TYPICAL BASE METALS

- 304L stainless steel
- 18/8 steels with service temperatures down to -196°C (-320°F)

DIAMETERS / PACKAGING

Diameter in (mm)	33 lb (15kg) Steel Spool
0.035 (0.9)	ED034909
0.045 (1.1)	ED034910

WIRE COMPOSITION⁽¹⁾ – As Required per AWS A5.9

	%C	%Cr	%Ni	%Mo	%Mn
Requirements AWS ER308L	0.03 max	19.5 - 22.0	9.00 - 11.00	0.75 max	1.0 - 2.5
Typical Results⁽³⁾	0.01	19.7	9.7	0.17	1.7
	%Si	%P	%S	%Cu	FN
Requirements AWS ER308L	0.30 - 0.65	0.03 max	0.03 max	0.75 max	Not Required
Typical Results⁽³⁾	0.37	0.02	0.01	0.18	3-6

MECHANICAL PROPERTIES⁽¹⁾

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft•lbf) -196°C (-320°F)	Lateral Expansion mils (mm) -196°C (-320°F)
Typical Results⁽³⁾ As-Welded with 98% Ar/2% O ₂	430 (63)	600 (88)	35	34 (47)	24 (0.61)

⁽¹⁾Typical wire composition ⁽²⁾Measured with 0.2% offset ⁽³⁾See test results disclaimer

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m³ maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.