LINCOLNWELD® 308/308LCF

Stainless ▪ AWS ER308/308L

KEY FEATURES

- Controlled Low Ferrite (Range 3-8)
- 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® - Certificate showing deposit composition, ferrite number, and charpy impact properties tested at -196C(-320F)
- Batch Managed Inventory

CONFORMANCES

AWS A5: ER308, ER308L

TYPICAL APPLICATIONS

- LNG Storage
- Cryogenic Vessels and Piping

RECOMMENDED FLUX

Lincolnweld® P2007

TYPICAL BASE METALS

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

DIAMETERS / PACKAGING

Diameter in	Diameter (mm)	55 lb (25 kg) Steel Coil
5/64	(2.0)	ED034914
3/32	(2.4)	ED034915
1/8	(3.2)	ED034916

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 Lincolnweld P2007	410 (59)	570 (82)	32	48 (36)	17 (0.43)

WIRE COMPOSITION[1] – *As Required per AWS A5.9*

	%C	%Cr	%Ni	%Mo	%Mn
Requirements AWS ER308/308L	0.03 max	19.5-22.0	9.0-11.0	0.75 max	1.0-2
Typical Results[3]	0.03	19.9	10.8	0.12	1.8
	%Si	**%P**	**%S**	**%Cu**	**FN**
Requirements AWS ER308/308L	0.30-0.65	0.03 max	0.03 max	0.75 max	Not required
Typical Results[3]	0.35	0.02	0.01	0.14	3-8

[1]Typical all weld metal [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.