

# 308L

## Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	88,500 psi
Yield Strength:	59,500 psi
Elongation:	39%

## Recommended Parameters

GMAW (DCEP – Electrode+) 99% Argon / 1% CO<sub>2</sub>, or a 97% Argon / 3% CO<sub>2</sub> Mixture  
For Solid Wire

Wire Diameter	Voltage	Amperage
0.035"	26-29	160-210
0.045"	28-32	180-250
1/16"	29-33	200-280

GTAW (DCEN – Electrode -) 100% Ar 2% Thoriated

Filler Wire Size	Tungsten Dia.	Voltage	Amperage	Argon (CFH)
1/16"	1/16"	12	80-150	20
3/32"	3/32"	12	150-250	20
1/8"	1/8"	12	200-375	25