

PRIMALLOY™ JW-308L



CONFORMANCE

- AWS A5.9/A5.9M: ER308L
- ASME SFA-5.9 ER308L

APPROVALS

- ISO 9001 Quality Management System
- JIS Quality Management System

APPLICATIONS

- Offshore
- Petrochemical Equipment
- Shipbuilding
- Boiler & Pressure vessel

DIAMETERS AVAILABLE

- 2.0mm
- 2.4mm
- 3.2mm
- 4.0mm

WELDING POSITIONS



1G



2F

PRODUCT FEATURES

- Stainless steel SAW wire
- Used with stainless steel flux JFS-601
- Designed for the welding of ASTM 304L and similar 18%Cr-8%Ni series austenitic stainless steels
- Stable arc provides good bead appearance and excellent slag removal
- Balanced chromium and nickel levels provide enough ferrite in the weld metal for high resistance to hot cracking.
- Low carbon weld metal provide high resistance to intergranular corrosion
- Unique manufacturing technology results in a clean wire surface and an even amount of feeding lubricant. These advantages ensure lower friction during wire feeding and better electrical conductivity.

STANDARD PACKAGING

- 25kg/coil

* Please contact your local Lincoln Electric sales office for alternative types of packaging.

PRIMALLOY™ JW-308L**CHEMICAL COMPOSITION OF SOLID WIRE(Wt-%)**

PRIMALLOY™ JW-308L	C	Mn	Si	P	S	Ni	Cr
AWS Requirement	0.03 max.	1.0-2.5	0.30-0.65	0.03 max.	0.03 max.	9.0-11.0	19.5-22.0
Typical Value	0.023	1.80	0.14	0.014	0.003	9.82	19.80

CHEMICAL COMPOSITION OF WELD DEPOSIT(Wt-%), TYPICAL

Wire/Flux	C	Mn	Si	P	S	Ni	Cr
PRIMALLOY™ JW-308L / JFS-601	0.035	1.45	0.64	0.025	0.006	9.62	18.98

MECHANICAL PROPERTIES OF ALL-WELD-METAL

PRIMALLOY™ JW-308L / JFS-601	Yield Strength Rp0.2 (Mpa)	Tensile Strength (Mpa)	Elongation (%)
AWS Requirement	Not Specified	520	35
Typical Value	435	535	43

RECOMMENDED WELDING PARAMETERS (POLARITY: DC+)

Diameter (mm)	Wire Feed Speed (m/min)	Voltage (V)	Current (A)
2.0	2.0-6.1	24-30	190-500
2.4	1.5-5.3	26-32	195-575
3.2	0.9-2.8	28-34	200-700
4.0	0.8-1.9	30-36	320-775

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

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