



DESCRIPTION

Stainless steel TIG rods with **very low carbon content**, certified by the **CWB (Canadian Welding Bureau)**, for welding a wide range of stainless steel grades (301, 302, 304, 304L, 308, 308L, 309, 309L, 316, 316L, 317, 317L, 318, 321, 347, etc.)

CHARACTERISTICS

- Certified by CWB to CSA W48-06 (except for diameters 1.2 mm and less)
- Conforms to specifications : AWS A5.9 and ASME SFA 5.9
- Excellent weldability characteristics
- Low carbon filler metal
- Available in several diameters

MECHANICAL PROPERTIES

Selectarc TIG 308L : Tensile strength = 87 000 psi (600 MPa) ; Elongation = 38 %

Selectarc TIG 309L : Tensile strength = 89 900 psi (620 MPa) ; Elongation = 35 %

Selectarc TIG 316L : Tensile strength = 94 300 psi (650 MPa) ; Elongation = 38 %

WELDING SPECIFICATIONS

Selectarc TIG 308L = welding of stainless steel grades 301, 302, 304L, 308, 308L, 321 and 347

Selectarc TIG 309L = welding of stainless steel grades 309, 309L, 304, 304L, 308 and 308L

Selectarc TIG 316L = welding of stainless steel grades 316, 316L, 317, 317L and 318

WELDING PARAMETRES

Diameter : 3.2 mm (1/8"), 2.5 mm (3/32"), 1.6 mm (1/16"), 1.2 mm (.045")

Polarity : DC-

Gas : Pure argon

Gas flow : 35 – 40 CFH

Complete range of stainless steel electrodes certified CWB

MIG wires certified CWB : Selectarc MIG 308LSi, Selectarc MIG 309LSi and Selectarc MIG 316LSi

Flux-cored wire with slag AP (all position) : FC 308L-AP, FC 309L-AP, FC 316L-AP

Flux-cored wire with slag FP (flat and horizontal) : FC 308L-FP, FC 309L-FP, FC 316L-FP

Other stainless steel grades available on request

Rév.: 21_08

Specialized welding alloys and technology. For technical assistance or for ordering: