

Shield-Bright 308L

Shield-Bright 308L was developed for welding type 304L stainless steel and can also be used for welding types 301, 302 and 304. It may also be used for welding types 321 and 347 if the service conditions do not exceed an approximate of 750 (399).

Specifications

Classifications

SFA/AWS A5.22 : E308LT1-1
SFA/AWS A5.22 : E308LT1-4
JIS Z 3323 : TS308L-FB1
KS D 3612 : YF 308LC
EN ISO 17633-A : T 19 9 L P C1 2
EN ISO 17633-A : T 19 9 L P M21 2

Approvals

NAKS/HAKC : 1.2 mm
LR : 304L (M21)
ABS : E308LT1-1 (C1)
ABS : E308LT1-4 (M21)
BV : 308L (C1)
CCS : 308L (C1)
CE : EN 13479
ClassNK : KW308LG(C) (C1)
CWB : E308LT1-1 (C1)
CWB : E308LT1-4 (M21)
DNV-GL : VL 308L (C1)
DNV-GL : VL 308L (M21)
KR : RW308LG (C) (C1)
LR : 304L (C1)
VdTÜV : 04832 (M20, M21)

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current

DC+

Alloy Type

Austenitic Cr-Ni

Typical Tensile Properties

Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
M21 shielding gas				
As Welded	As welded	410 MPa	580 MPa	44 %
C1 shielding gas				
As Welded	As welded	372 MPa	568 MPa	61 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas		
As Welded	-29 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
M21 shielding gas				
0.030	1.20	0.90	10.1	19.30
C1 shielding gas				
0.025	1.10	0.70	10.00	19.10

Deposition Data

Diameter	Current	Voltage
1.6 mm	160-320 A	24-33 V

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Deposition Data

Diameter	Current	Voltage
1.2 mm	130-220 A	24-29 V