

Material Type					
AISI 304L		1.4306		X2CrNi19-11	
Characteristics					
WAAM solid wire designed for 3Dprinting of austenitic alloy 304L structures.					
Typical analysis of the solid wire (wt.-%)					
	C	Mn	Cr	Ni	N
wt.-%	0.02	1.6	20.0	10.0	<0.1
Post weld heat treatment to increase toughness or strength.					
Available products					
Diameter: 1,0 mm – 1,2 mm					
Package: BS300 15 kg – ECOdrum 100 – ECOdrum 250 – S760 300					
Other diameters and packages on request.					
Typical mechanical properties acc. to EN ISO 15792-1					
Heat treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation (L <sub>0</sub> =5d <sub>0</sub> )	Impact energy ISO-V KV J	
	MPa	MPa	%	-196 °C	
u	380	620	48	≥ 32	
u untreated, shielding gas Ar + 2 % CO <sub>2</sub>					
Classification as welding consumable:					
EN ISO 14343-A		AWS A5.9			
G 19 9 L		ER308L			