AS MIG 308LSi

MIG Wire for Welding of Austenitic Stainless Steels

Classification

AWS A5.9 : ER308LSi
ISO 14343-A : G 19 9 LSi

General Description

Solid wire with extra low carbon for welding austenitic CrNi-steels.

With increased silicon for improved wettability.

Chemical Composition (w%), Typical, Wire

C	Si	Mn	Cr	Ni	Mo	P+S
< 0.03	0.85	1.70	20	10	0.15	< 0.035

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 390 N/mm²
Tensile Strength : 590 N/mm²
Elongation (L=5d) : 40 %
Impact ISO-V : 120 J (+20°C)

Approvals

ABS (ER308LSi)

GOST, SEPRO

Shielding Gases (acc. ISO 14175 and EN 439)

MIG : M13 - Ar + % 1.5 - 3 O_2
M12 - Ar + % 1 - 5 CO_2

Materials to be Welded

	EN 10088-1/-2	EN 10213-4	Mat. Nr.
Extra Low Carbon (C < %0.03)	X2 CrNi 19 11 X2 CrNiN 18 10		1.4306 1.4311
Medium Carbon (C > %0.03)	X4 CrNi 18 10	G-X5 CrNi 19 10	1.4301 1.4308
Ti/Nb Stabilized	X6 CrNiTi 18 10 X6 CrNiNb 18 10	G-X5 CrNiNb 19 10	1.4541 1.4550 1.4552

Packaging and Available Sizes

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Spool Weight
MIG Wire	X	X	X	-	-	-	-	12.5 kg