

## 308 LSi Tig

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Stainless steel Tig filler metal for welding CrNi 18/10 types.

**APPLICATIONS** Boilers, agriculture, liquid storage tanks, food machinery, furniture.

**PROPERTIES** 308LSi has good general corrosion resistance. The alloy has a low carbon content, making it particularly recommended where there is a risk of intergranular corrosion. The higher silicon content improves the welding properties such as wetting.

**CLASSIFICATION**

AWS	A 5.9: ER 308LSi
EN ISO	14343-A: W 19 9 L Si
DIN: W.Nr.	1.4316
DIN	8556: SG X2CrNi 19 9

**SUITABLE FOR**

W.Nr: 1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4546, 1.4312, 1.4300, 1.4312, 1.4371, 1.4541, 1.4543, 1.4550, 1.4452

DIN X2CrNi 19 11 (TP), X4CrNi 18 10 (TP), X6CrNiTi 18 10 (TP), X6CrNiNb 18 10 (TP), X2CrNiN 18 10 (TP), X5CrNiNb 18 10, G-X10CrNi 18 8 (TP),

AISI 202, 302, 304L, 304, 305, 321, 347, 304 LN

ASTM A320 Grade B8C/D, 302

**APPROVALS** TUV (12387.00), DB (43.206.02), CE approved

**WELDING POSITIONS:**



**WELD METAL WEIGHT %**

C	Mn	Si	Cr	Ni	Mo	P	S
<0.03	1.0-2.5	0.65-1.0	19.5-22.0	9.0-11.0	<0.75	<0.03	<0.03

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-60°C	-196°C	
AW	480	630	37	170	150	75	

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing	
	Current (A) DC-		single	master
1.0 x 1000	20-50		5	25
1.2 x 1000	30-70		5	25
1.6 x 1000	50-80		5	25
2.0 x 1000	70-110		5	25
2.4 x 1000	110-180		5	25
3.2 x 1000	150-250		5	25

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** I1