

MIG / TIG 308LSi



MIG/TIG 308 LSi is used to weld 18/8 stainless steels including 301, 302, 303, nitrogen bearing 304LN and similar. Service temperatures are typically -100°C to about 400°C. Applications can be found in the brewery, food, architectural and general fabrication industries.

CLASSIFICATIONS

AWS	A5.9	ER308LSi
BS EN	12072	19 9 L Si
DIN	8556	SG X2CrNi 19 9 (1.4316)

CHEMICAL ANALYSIS

% Carbon	0.010	% Chromium	20.00
% Manganese	1.700	% Nickel	10.00
% Silicon	0.80	% Molybdenum	0.100
% Sulphur	0.010	% Copper	0.150
% Phosphorus	0.015	% Ferrite	10.00

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

	MIG	TIG
Tensile Strength	570 MPa	605 MPa
0.2% Proof Stress	435 MPa	465 MPa
Elongation on 4d	42%	35%
Impact Energy -20°C	30 - 60J	80J

Microstructure
Austenite with a controlled level of ferrite, normally in the range 2-10FN.

PACKING DATA

MIG (DC+)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
0.80	120	19	033-013	15
0.90	160	23	033-014	15
1.00	200	26	033-224	15
1.20	260	26	033-222	15
1.60	280	28	033-017	15

TIG (DC-)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.60	100	12	030-413	5
2.00	100	12	030-414	5
2.40	100	12	030-415	5

Suggested gas for welding : Stainshield Plus, Stainshield (MIG), Argon (TIG)

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