

## Key Facts

- Precision Layer wound wire
- Low Carbon content for 18/8 stainless steels
- Easy starting and Smooth feeding wire
- Higher Silicon content improves weld edge wetting

## Description

Precision layer wound, premium quality, low carbon stainless steel wire for welding wide range of austenitic 18/8 type stainless steel pipes, plates, forgings & castings. The low carbon content prevents carbide precipitation & intergranular corrosion.

## Classification

AWS A5.9 ER308LSi

## Recommended Shielding Gas

98/99% Argon + 2/1% Oxygen  
97% Argon + 3% CO<sub>2</sub>

## Approvals and Conformances

AWS A5.9 ER308LSi  
JIS Z3221 Y 308LSi  
DIN8556 SG X2 CrNi 19 9

## Welding Positions

All Positional; Flat, horizontal, vertical-up, vertical-down and overhead.

## Applications

Use for welding wide a range of austenitic 18/8 type stainless steel pipes, plates, forgings and castings. Typical applications include welding of AISI308L in chemical, oil and gas refineries, stainless steel sheet metal works and rail car fabrication.

- Petrochemical industry
- Food processing equipment manufacture and repair
- Boiler tubes and pipes
- Sheet metal fabrication

## Typical Wire Analysis

C - Carbon	Mn - Manganese	Si - Silicon	Cr - Chromium
< 0.03	1.0 – 2.5	0.65 – 1.00	19.5 – 22.0
Ni - Nickel	Mo - Molybdenum	S - Sulphur	Cu - Copper
9.0 – 11.0	< 0.75	< 0.03	< 0.75
P - Phosphorus	Fe - Iron		
< 0.03	Remainder		

## Typical All Weld Metal Mechanical Properties

<b>0.2% Proof Stress:</b>	395N/mm
<b>Yield Strength:</b>	410 MPa
<b>Tensile Strength:</b>	591 MPa
<b>Elongation:</b>	42%
<b>Impact Strength ISO-kV:</b>	140J @ +20 °C 80J @ -196 °C

## Packaging & Ordering Information

Size	Packet	Part Number
0.8mm	15kg	200035
0.8mm	5kg	200030
0.9mm	15kg	200036
0.9mm	5kg	200031
1.2mm	15kg	200037