

ELBOR STAINLESS STEEL MIG WIRE / TIG RODS - AWS A 5.9 308 LSI

The 308LSi is primarily intended for welding the low carbon 18% Cr / 10% Ni, type 304L, austenitic stainless steels. It is also suitable for stainless steel grade 304 material and the Nb or Ti stabilized grades 347 and 321, provided service temperatures for structural work are below 400°C. The higher silicon content provides a more fluid weld pool which may be preferred for certain welding applications.

NORM: EN ISO 14343-A-G/W 19 9 L Si - WERKSTOFF. 1.4316

MATERIAL TO BE WELD :

304/304L/304LN/ A 157 Gr C9/A 320 Gr B8C,D/CF3/CF8

TYPICAL CHEMICAL CONTENT :

Mo	0.10-0.15
Cr	19.00-20.00
Ni	9.00-11.00
Mn	1.50-3.00
Si	0.10
Cu	0.10
C	0.02

AWS A 5.9: ER308LSi

EN ISO 14343-A: G 19 9 L Si

Elongation	40 %
Impact Strength Kv (+20°C)	>47 J
Tensile Strength	590 MPa
Yield Strength	400 MPa

TYPICAL MECHANICAL PROPERTIES ALL WELD METAL:

Impact Strength Kv (+20°C)	110 J
Impact Strength Kv (- 60°C)	90 J
Impact Strength Kv (- 200 °C)	60 J

Welding positions :

