



Product Data Sheet

G 'Gas-shielded metal-arc welding'

AlloyRod 308LSi MIG

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REASON FOR ISSUE

New Product

GENERAL

AlloyRod 308LSi is a solid corrosion resisting 18%Cr- 8% Ni wire for welding similar alloys. The higher Si content improves welding properties such as wetting and fluidity.

Shielding Gas: M12, M13 (EN ISO 14175)

Alloy Type: Austenitic (with approx. 8% ferrite) 19% Cr- 9% Ni-Low C- High Si

CLASSIFICATIONS Wire Electrode

EN ISO 14343-A G 19 9 L Si
SFA/AWS A5.9 ER308LSi

APPROVALS

CE EN 13479
UKCA EN 13479

CHEMICAL COMPOSITION

All Weld Metal (%) Wire/Strip (%)

	Nom	Min	Max	Nom
C	0.020		0.03	0,020
Si	0.85	0.65	1.00	0,85
Mn	1.7	1.0	2.5	1,70
P	0.025		0.03	0,025
S	0.005		0.02	0,01
Cr	19.8	19.5	21.0	20,0
Ni	9.5	9.0	11.0	9,5
Mo	0.05		0.5	0,05
Nb	0.005			0,005
Cu	0.05		0.5	0,05
N	0.09			0,10
FN WRC-92	8			8
Ferrite FN	5			

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Standard	Condition	Rp0.2 [MPa/ksi]		Rm [MPa/ksi]			A4 [%]		A5 [%]	
		Min	Typ	Min	Max	Typ	Min	Typ	Min	Typ
AWS	As welded		600/87	520/75		670/97	35	40		
EN ISO	As welded	320/46	600/87	510/74		670/97			25	35

Comments:

Standard	Condition	Temp [°C/°F]	Charpy V [J/ft-lb]	
			Min	Typ
AWS	As welded	20/68 -196/-321		150/111 60/44
EN ISO	As welded	20/68 -196/-321		150/111 60/44

Comments:

