



CrInoxTIG 308LSi

Solid wire Gas
Tungsten Arc Solid

Classifications EN ISO 14343-A W 19 9 L Si
AWS A5.9 ER308LSi

CrInoxTIG 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 stabilised 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.

Shielding Gas I1, Ar 99.99%, 6-12 l/min **Welding Current** DC-

Scaling temperature

Corrosion resistance Good resistance to general and intergranular corrosion. Also good resistance to oxidising acids and cold reducing acids.

Weld metal chemistry % FN > 6

	%C	%Si	%Mn	%P	%S	%Cr	%Ni	%Mo	%Cu
Min		0,65	1,5			19,5	9,0		
Typical	0,023	0,88	1,80	0,025	0,01	19,65	9,15	0,10	0,15
Max	0,030	1,00	2,0	0,030	0,020	21,0	11,0	0,50	0,50

Notes :

Mechanical properties Welding Conditions : As Welded

Typical values			T °C	Typical (J)
Yield Strength, Re	400 MPa		20	120
Tensile Strength, Rm	600 MPa		-196	45
Elongation A5	35 %			

Minimum values		
Yield Strength, Re	320 MPa	
Tensile Strength, Rm	510 MPa	
Elongation A5	35 %	

CE	TÜV	DB	LR	DNV	BV	ABS	RINA	RMS	NAKS
X	X	X - Pending							

Available diameters : 1,6 - 2,4mm

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