



GMAW / GTAW STAINLESS STEEL
MIGINOX 308LSi

308LSi TYPE STAINLESS STEEL SOLID WIRE



CLASSIFICATION : EN ISO 14343-A AWS A/SFA 5.9 **APPROVALS :**

G 19 9 LSi

ER308LSi

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KEY FEATURES :

- An extra low carbon 20Cr/10Ni type stainless steel solid wire
- High Si content improves wetting characteristics
- Resists intergranular corrosion
- Controlled ferrite content ensures excellent crack resistance
- Excellent corrosion & scaling resistance up to 800°C
- Radiographic quality welds

WELDING POSITION :



GMAW: DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
98Ar/2O ₂ or Ar/1-5CO ₂	15-22	10-20

TYPICAL APPLICATIONS :

- Welding Cr-Ni steels represented by AISI 301, 302, 304, 304L, 308, 308L
- Fabrication of boilers, reactors, turbines, pipes, tubes
- SS piping in refineries, oil and gas industries, chemical plants, food processing industries

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.03 max	1.0-2.5	0.65-1.0	19.5-22.0	9.0-11.0	0.75 max	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	520 min	35 min

Mechanical properties will vary with the type of shielding gas used.

PACKING DATA :

Ø, mm	Kg/Spool
0.8	12.5
1.2	12.5
1.6	12.5
2.0	12.5