Cromamig 308LSi

GMAW - MIG MAG

Stainless Steel

Date: 2008-01-22
Revision: 9

Description:
Cromamig 308LSi is primarily intended for welding the low carbon 18% Cr / 10% Ni type 304 L austenitic stainless steels. Suitable also for welding normal carbon grade 304 and Nb or Ti stabilised steels (347, 321) provided service temperatures are below 400°C. The higher silicon content gives better arc stability and weld metal flow which improves bead appearance, particularly when dip transfer welding.

Welding current:
DC+

Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,65	1,0			19,0	9,0
Typical	0,02	0,80	1,75	0,02	0,01	20,0	10,0
Max	0,030	1,00	2,5	0,03	0,020	21,0	11,0

	Mo	Cu	N
Min			
Typical	0,1	0,1	
Max	0,30	0,5	0,06

Shielding gas:
Acc. to EN 439:
M12, Ar + 2% CO2, 16-21 l/min
M13, Ar + 1-3% O2, 16-21 l/min

Ferrite content:
FN 9

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

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,015	0,75	1,7	0,02	0,01	20,0	10,0
Max							

	Mo	N
Min		
Typical	0,1	0,05
Max		

Mechanical properties

	Specified	Typical
Yield strength, Rp0.2%:	≥ 350 MPa	400 MPa
Tensile Strength, Rm:	≥ 520 MPa	590 MPa
Elongation, A5	≥ 35%	40%
Impact energy, CV:		20°C • 120 J
		-196°C • 50 J

Classification:

EN ISO 14343	G 19 9 LSi
AWS A5.9	ER308LSi

Approvals:

DB	Kennblatt Nr 43.042.12
TÜV	
CE	

Product data

Diam.mm	Product code	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
0,8	9802-2008	60-100	18-21	150-170	24-26
1,0	9802-2010	75-140	18-21	170-200	26-28
1,2	9802-2012	130-160	18-21	175-250	26-28