

ES MIG 308LSi

GMAW
ER308LSi

ESWECO
The Art of Welding

Description

ES MIG 308LSi a continuous, solid, corrosion-resistant, chromium-nickel wire for welding austenitic chromium-nickel alloys of the 18 Cr-8% Ni type. ES MIG 308LSi has good general corrosion resistance.

The alloy has a low carbon content, making it particularly recommended where there is a risk of intergranular corrosion. The higher silicon content improves the welding properties such as wetting.

The alloy is widely used in the chemical and food processing industries, as well as for pipes, tubes and boilers.

Current

DC+

Classifications

SFA/AWS A5.9	ER308LSi
EN 12072	G 19 9 LSi
Werkstoffnummer	~1.4316

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.8	1.8	20.3	10.0	<0.3	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	370
Tensile strength, MPa	620
Elongation, %	36

Charpy V

Test temps, °C	Impact values, J
+20	110
-60	90
-196	60

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V
0.8	4.0-17.0	55-160	15-24
1.0	4.0-16.0	80-240	15-28
1.2	3.0-14.0	100-300	15-29
1.6	5.5-9.0	230-375	23-29