Lincoln MIG 308LSi

Stainless steel solid wire

Classification

AWS A5.9 : ER308LSi
ISO 14343-A : G 19 9 Lsi

General description

Solid wire with extra low carbon for welding austenitic CrNi-steels
With increased silicon for improved wettability

Shielding gases (acc. ISO 14175)

M12 Mixed gas Ar+ >0-5% CO_2
M13 Mixed gas Ar+ >0-3% 02

Chemical composition (w%) typical wire / rod

C	Mn	Si	Cr	Ni	Mo
0.010	1.7	0.8	20	10	0.2

Mechanical properties, typical, all weld metal

	Shielding gas	Condition	0.2% Proof strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact ISO-V(J) -20°C	Impact ISO-V(J) -196°C
Typical values	M12	AW	420	570	45	85	55

Materials to be welded

Steel grades	EN 10088-1/-2	EN 102 13-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Extra low carbon (C < 0.03%)					
	X2CrNi19 11		1.4306	(TP)304 L	S30403
				CF-3	J92500
	X2CrNiN18 10		1.4311	(TP)304LN	S30453
				302, 304	S30400
Medium carbon (C > 0.03%)					
	X4CrNi18 10		1.4301	(TP)304	S30409
		GX5CrNi19 10	1.4308	CF-8	J92600
Ti-,Nb stabilized					
	X6CrNiTi18 10		1.4541	(TP)321	S32100
				(TP)321H	S32109
	X6 CrNiNb 18 10		1.4550	(TP)347	S34700
		GX5 CrNiNb 19 10	1.4552	CF-8C	J92710

Packaging and available sizes

Unit type	Diameter (mm) 0.8	1.0	1.2	1.6
15 kg spool BS300	X	X	X	X

Other sizes and packaging on request