MIGWELD 308LSi

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : G 19 9 LSi DIN 8556 : SG-X2 CrNi19 9 AWS A-5.9 : ER 308 LSi W.Nr. : 1.4316	TUV DB	Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Agriculture Light construction and hobby

- Solid welding wire for welding homogeneous stainless steels, resistant to corrosion.
- Suitable for use in all industries where homogeneous steel grades and ferritic steels with 13% chromium content, up to a temperature of 350°C, are welded.
- The weld deposit is resistant to oxidation up to 800°C and maintains plasticity down to -196°C.

Application

Food processing equipment, beer brewing (yeast vats, fermentation vats), milk processing, pharmaceutical equipment, winemaking, manufacturing of fasteners, flanges, architectural applications (roofing, urban accessories, cladding, doors, windows), automotive and aerospace components, heat exchangers, pipes, sanitary products, tanks and containers, milk trucks, citrus and other fruit processing industry, balustrades, dyeing industry, construction materials.

Base material

AISI/ASTM	EN 10088-1/2	EN 10213-4	W.Nr	PN
304L	X2 CrNi 18 11		1.4306	00H18N10
304LN	X2 CrNiN 18 10		1.4311	
	X4 CrNi 18 10	GX5 CrNi 19 10		
	X6 Cr 13		1.4308	
304	X5 CrNi 18 10		1.4301	0H18N9
321	X6 CrNiTi 18 10		1.4541	1H18N9T
347	X6 CrNiNb 18 10		1.4550	H18N12Nb
		GX5 CrNiNb 19 10	1.4552	
302	X12 CrNi18 8		1,4300	
305		GX10 CrNi 18 8	1.4312	
304H	X6 CrNi18 11		1.4948	
308	X5 CrNi18 11		1.4303	
347	X5 CrNiNb18 9		1.4543	
301			1.4310	1H18N9
	X10 CrNiNb18 10		1.6905	
405	X7 CrAl13		1.4002	
410	X10 Cr13		1.4006	
430	X8 Cr17		1.4016	
410/420	X15 Cr13		1.4024	
420	X20 Cr13		1.4021	
	X7 CrNiNb18 10		1.4546	
201LN, 201L	X2 CrMnNiN17 7 5		1.4371	
P2000	X13CrMnMoN18 14 3		1.4452	

301L	X5 CrNi17 7		1.4319	

Typical chemical composition %

C	Si	Mn	Cr	Ni
<0,025	0,70	2,00	19,00	9,00

Typical mechanical properties

Yield strength Re [N/mm2]	>320
Tensile strength Rm [N/mm2]	550-650
Elongation A5 [%]	>30
Impact energy Kv [J]	> 80 J (20°C) / >32J (-196°C) /
Wire/rod type	solid
Ferrite content	about 6 FN
Welding current	
Welding positions	
Additional description	Structure: Austenite + Ferrite
Shielding gases acc. to EN ISO 14175	I1 - Ar / M12 - Ar + 0.5 - 5% CO2 / M13 - Ar + 0.5 - 3% O2 /

Welding parameters and packing

⌀	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	100-160	18-22	15,0
1,0	140-200	18-24	15,0
1,2	170-260	20-28	15,0
1,6	220-350	24-36	15,0

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