



AWS A5.9: ER308LSi  
ISO 14343-A-2009 19 9 LSi

## Stainless Steel Solid Wire MIG/TIG Welding

### SW-308LSi

#### DESCRIPTION & APPLICATION

MIG/TIG Filler wire for the joining and overlay of Stainless Steels of similar composition such as AISI 304L Low carbon content minimises Carbide precipitation. Higher silicon content than 308L gives increased fluidity.

#### BASE MATERIALS

All 300 series Austenitic Stainless Steel, particularly 304, overlay of Mild Steel (Cladding) Joining of Austenitic Manganese Steels (Hadfields).

#### MECHANICAL PROPERTIES

~600

UTS n/mm

~380

YIELD 0.2%

>35

ELONG A5%

>35

CV (J) -196°C

#### METAL WELD COMPOSITION %

**C**

0.012

**Si**

0.85

**Mn**

1.9

**Cr**

19.5

**Ni**

10.5

**Mo**

0.05

**S**

0.002

**P**

0.02

**Fe**

BAL

#### PACKAGING

15kg Spools (MIG)  
5kg Tubes (TIG)

#### DIAMETERS

0.8, 1.0, 1.2mm (MIG)  
1.6, 2.4, 3.2mm (TIG)

#### WELDING INSTRUCTIONS

Shielding gas 5% or 20% CO<sub>2</sub> in Argon, or 2% Argon-Ox (MIG). 100% Argon (TIG). Do not allow the base material to overheat, maintain interpass temperature below 150°C.

25

Stainless Steels