



Cromatig 308LSi

GTAW - TIG
Stainless Steel

Date: 2020-06-11
Revision: 12

Description:

Cromatig 308LSi is primarily intended for welding the low carbon 18% Cr / 10% Ni, type 304L, austenitic stainless steels. It is also suitable for stainless steel grade 304 material and the Nb or Ti stabilised grades 347 and 321, provided service temperatures for structural work are below 400°C. The higher silicon content provides a more fluid weld pool which may be preferred for certain welding applications.

Welding current:

DC-

Wire composition, wt. %

	C	Si	Mn	P	S	Cr	Ni
Min		0,65	1,5			19,5	9,0
Typical	0,02	0,8	1,75	0,02	0,01	20,0	10,0
Max	0,025	1,00	2,0	0,03	0,020	21,0	11,0

	Mo	Cu	N
Min			
Typical	0,10	0,10	
Max	0,30	0,30	0,075

Shielding gas:

Acc. to EN 439:

I1, Ar 99.99%, 6-12 l/min

Stamping

Elga, AWS, Wst, EN, Batch

Ferrite content:

Min FN acc. WRC92 = 6

Corrosion resistance

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

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 320 MPa	400 MPa
Tensile Strength, Rm:	≥ 510 MPa	590 MPa
Elongation, A5	≥ 35%	40%
Impact energy, CV:		20°C • 120 J -196°C • 50 J

Classification:

EN ISO 14343

W 19 9 LSi

AWS A5.9

ER308LSi

Approvals:

DB

Kennblatt Nr 43.042.12

TÜV

CE

Product data

Diam.mm	Length mm
1,2	1000
1,6	1000
2,0	1000
2,4	1000
3,2	1000

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