MIG Consumables

M-308LSi

For austenite stainless steel (Low carbon 18%Cr-8%Ni STS)

KISWEL

Classifications

EN ISO 14343-A:2009	: G 19 9
EN ISO 14343-B:2009	: SS 308L
AWS A5.9-2012	: ER308LSi
JIS Z 3321:2013	: YS308LSi

Approvals

Other	: TUV

Description

- MIG welding of 18%Cr-8%Ni austenite stainless steels (AISI STS 301, 302, 304)
- Various applications of petrochemical and nuclear power plant apparatus

Welding positions

Polarity & shielding gas

- DCEP (DC+)
- Ar + 1-3% O_2 (15 – 25 l/min)
- Ar + 1-5% CO_2 (15 – 25 l/min)

Typical chemical composition of all-weld metal (%)

C	Si	Mn	Ni	Cr
0.01	0.85	1.68	9.89	19.63

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)	
	(MPa)	(MPa)	(%)	0 °C	-196 °C
AWS A5.9		Min. 520	Min. 35		
EN ISO 14343	Min. 320	Min. 510	Min. 30		
Example	399	619	43	114	60