

Classifications

| EN ISO 14343-A | EN ISO 14343-B | AWS A5.9 | W. No. |
|----------------|----------------|----------|--------|
| G 19 9 L Si | SS308LSi | ER308LSi | 1.4316 |

Characteristics and typical fields of application

GMAW solid wire of type G 19 9 L Si / ER308LSi designed for first class welding, wetting and feeding characteristics and excellent weld metal CVN values down to $-196\text{ }^{\circ}\text{C}$.

Resistance to intergranular corrosion up to $+350\text{ }^{\circ}\text{C}$.

Base materials

1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2CrNi18-10, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10

AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 Gr. C9, A320 Gr. B8C or D

Typical analysis of solid wire (wt.-%)

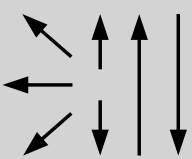
| | C | Si | Mn | Cr | Ni |
|-------|-------------|-----|-----|------|------|
| wt.-% | ≤ 0.02 | 0.8 | 1.7 | 20.0 | 10.2 |

Mechanical properties of all-weld metal

| Condition | Yield strength $R_{p0,2}$ | Tensile strength R_m | Elongation A ($L_0=5d_0$) | Impact work ISO-V KV J | |
|-----------|------------------------------|---------------------------|--------------------------------|-------------------------------|--------------------------------|
| | MPa | MPa | % | $+20\text{ }^{\circ}\text{C}$ | $-196\text{ }^{\circ}\text{C}$ |
| u | 390 (≥ 320) | 540 (≥ 510) | 38 (≥ 35) | 110 | (≥ 32) |

u untreated, as welded – shielding gas Ar + 2.5 % CO_2

Operating data

|  | Polarity: | Shielding gas: | \varnothing (mm) |
|---|-----------|----------------------------------|--------------------|
| | DC (+) | Argon + max. 2.5 % CO_2 | 0.8 |
| | | | 1.0 |
| | | | 1.2 |

Approvals

TÜV (03159.), DB (43.014.09), DNV (308L), GL (4550S), SEPROZ, CE