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MIG AND TIG STAINLESS STEEL WIRES.

Swiss Alloys® 308LSi

SPECIFICATIONS

AWS 5.9
ASME SFA 5.9
EN ISO 14343 EN steel no. 19 9 LSi

CLASSIFICATIONS

AWS ER308LSi
UNS S30888

DESCRIPTION / APPLICATION

Swiss Alloys ER308LSi is used to weld base metal of similar composition such as AISI 301, 302, 304, 304L, 305, 308, 308L and 347. This classification is the same as Swiss Alloys ER308L, except for the higher silicon. This improves the usability of the filler metal in the gas metal arc welding process. If the dilution by the base metal produces a low ferrite or fully austenitic weld, the crack sensitivity of the weld is somewhat higher than that of a lower silicon content weld metal.

Typical Chemical Analysis						
C	Cr	Ni	Mo	Mn	Si	P
0.03 max	19.5- 22.0	9.0- 11.0	.075 max	1.0- 2.5	0.65- 1.00	0.03 max
S	Cu					
0.03 max	0.75 Max					

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 85,000 psi 590 MPa
Yield strength: 57,000 psi 390 MPa
Elongation: 40%

Approvals CE, DB, TÜV

Typical Welding Parameters of Stainless steel wire			
Process	Diameter of Wire	Welding Voltage (V)	Welding Current (A)
TIG	0.80 mm	12 V - 15 V	60 A - 90A
	1.2 mm	13 V - 16 V	80 A - 110 A
	1.6 mm	14 V - 18 V	90 A - 130 A
	2.4 mm	15 V - 20 V	150 A - 220 A
	3.2 mm	15 V - 20 V	150 A - 220 A
MIG	1.0 mm	26 V - 29 V	150 A- 190 A
	1.2 mm	28 V - 32 V	180 A - 220 A
	1.6 mm	29 V - 33 V	200 A - 250 A