

## CLASSIFICATIONS

EN ISO 14343-A : G 19 9 L Si  
 AWS A5.9 : ER 308 LSi

## DESCRIPTION

- MIG welding of 13% Cr ferritic stainless steels, high-carbon steels of type 304 or stabilized steels of type 347, or steels of similar types, used in industries of drug, cellulose, paper, and food (production)
- Ar+2.5O<sub>2</sub> or Ar+2.5 CO<sub>2</sub> mixed gas is used as shielding gas
- Maintenance of ductile behavior at temperature values down to -196°C.
- Maintenance of resistance to intergranular corrosion at temperatures up to 350°C

## CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.02 | Si: 0.8 | Mn: 1.7 | Ni: 10.2 | Cr: 20.4

## MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>o</sub> =5d <sub>o</sub> ) (%)
min. 350	520 - 660	min. 63 J	min. 35

## BASE MATERIALS

- X2 CrNi 19 11, X5CrNi 18 10, X6 CrNiTi 18 10, X6 CrNiNb 18 10, X2 CrNiN 18 10, X10 CrNiNb 18 10
- AISI & ASTM: 304, 304L, 304LN, 321, 347, A320Gr.B8C, A320Gr.B8D

## WELDING POSITIONS



## CURRENT CONDITION

MIG D.C.(+)

## OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100025	0.8	0.030"	12.5	BS 300
1011100026	1.0	0.040"	15	BS 300
1011100027	1.2	0.047"	15	BS 300
1011100028	1.6	0.062"	15	BS 300