



# TIG308LSi



## Standards

AWS 5.9

EN ISO 14343-A

W. Nr.

**ER 308LSi**

**W 19 9 L Si**

**1.4316**

## Description & applications

Filler material in solid wire sticks for TIG welding of Molybdenum-free austenitic stainless steels type 304, 304L, 321, 347. Used for standard applications and moderate corrosion environments, for systems service conditions not exceeding 350°C. The high Silicon content improves the wettability of the molten weldment.

## Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Mo	S max	P max	Fe
<b>0.025</b>	<b>1.8</b>	<b>0.9</b>	<b>20.5</b>	<b>10.0</b>	<b>-</b>	<b>0.02</b>	<b>0.02</b>	<b>Base</b>

## Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV -196°C
<b>600 MPa</b>	<b>400 MPa</b>	<b>40 %</b>	<b>48 J</b>

## Operating parameters

Shielding gas recommendations :

EN ISO 14175 II : 100 % Argon 6-12 l/mn Root: Argon, Nitrogen : 3-6 l/mn



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