

CATEGORY	GMAW-GTAW Solid wires	
TYPE	High alloyed wire for welding CrNi 18/10 types.	
APPLICATIONS	Boilers, tanks, agriculture, liquid storage tanks, food machinery, furniture.	
PROPERTIES	Austenitic filler metal for stabilized and non-stabilized CrNi steels. Heat resistant up to 350°C. Excelent toughness properties down to -196°C.	
CLASSIFICATION	AWS	A 5.9: ER308LSi
	EN ISO	14343-A: G 19 9 L Si
	F-nr	6
	FM	5
	W.Nr.	1.4316

SUITABLE FOR	W.Nr:	1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4546, 1.4312, 1.4300, 1.4312, 1.4371, 1.4541, 1.4543, 1.4550, 1.4452
	DIN	X2CrNi 19 11 (TP), X4CrNi 18 10 (TP), X6CrNiTi 18 10 (TP), X6CrNiNb 18 10 (TP), X2CrNiN 18 10 (TP), X5CrNiNb 18 10, G-X10CrNi 18 8 (TP),
	AISI	202, 302, 304L, 304, 305, 321, 347, 304 LN
		ASTM A320 Grade B8C/D, 302

APPROVALS	TÜV (12386) CE DB (43.206.02)
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WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT %

C	Si	Mn	Cr	Ni	Mo	Cu
0.016	0.77	1.92	19.75	10.2	0.15	0.1

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	RT	Impact Energy (J) ISO-V	
					-60°C	-196°C
As Welded /	480	630	37	170	150	75

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A) DC+	SPOOL TYPE	KG SPOOL	KG / PALLET
0.6	-	-	D-200 / D-300	5 / 15	1000 / 1080
0.8	12-24	55-160	D-200 / S-300 / DRUM	5 / 15 / 250	1000 / 1080 / 1000
1.0	15-28	80-240	D-200 / S-300 / DRUM	5 / 15 / 250	1000 / 1080 / 1000
1.2	15-29	100-300	S-300 / DRUM	15 / 250	1080 / 1000
1.6	23-31	150-375	S-300 / DRUM	15 / 250	1080 / 1000

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175	M11, M13, M12
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