

CATEGORY	GMAW-GTAW Solid wires	
TYPE	High alloyed Tig rod 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: W 19 9 L Si
	F-nr	6
	FM	5

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 (TÜV (12387.00)) CE DB (DB (43.206.02))
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WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT %

C	Si	Mn	P	S	Cr	Ni	Mo
0.016	0.77	1.92	0.015	0.012	20.1	10.1	0.09

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

D (MM)	WELDING PARAMETERS		PACKING	
	CURRENT (A) DC-		SINGLE	MASTER
1.0 X 1000	20-50		5	25
1.2 X 1000	30-70		5	25
1.6 X 1000	50-80		5	25
2.0 X 1000	70-110		5	25
2.4 X 1000	110-180		5	25
3.2 X 1000	150-250		5	25

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175	I1
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