

Classifications

AWS A5.9	EN ISO 14343-A	GB/T 5092
ER308LSi	G 19 9 L Si	H 03 Cr 21 Ni 10 Si1

Characteristics and typical fields of application

- GMAW solid wire of type G 19 9 L Si / ER308LSi designed for high quality welding, good wetting and feeding characteristics and excellent weld metal CVN values down to -196 °C.
- Resistance to intergranular corrosion up to +350°C.

Base materials

1.4306 / X2CrNi19-11, 1.4301 / X5CrNi18-10, 1.4311 / X2CrNiN18-10.
 1.4312 / GX10CrNiN18-8, 1.4541 / X6CrNiNTi18-10, 1.4546 / X5CrNiNb18-10,
 1.4550 / X6CrNiNb18-10.
 AISI 304, 304L, 304LN, 302, 321, 347, AWS A157 Gr.C9, A320 GR.B8C or D

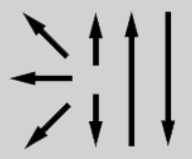
Typical analysis of all-weld metal

	C	Si	Mn	P	S	Cr	Ni		
wt-%	0.02	0.85	1.90	0.015	0.015	20.0	10.1		

Mechanical properties of all-weld metal – typical values (min. values)

Condition	Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-196 °C
AW	430 (≥ 320)	580 (≥510)	41(≥ 30)	110 (≥ 47)	- (≥32)

Operating data

	Polarity:	Electrode identification:	Shielding gas:	ø mm
	DC +	BÖHLER GMA 308LSi/ ER308LSi	ISO14175: M12	0.8 0.9 1.0 1.2

Approvals

CE, DB