

Exaton 308Si/308LSi

308Si/308LSi is a filler metal particularly suited for MIG/MAG welding. It is suitable for joining stainless steels of the 18Cr/8Ni ELC-type and 18Cr/8Ni/Nb type for service temperatures up to 350°C (660°F).

Classifications Wire Electrode	SFA/AWS A5.9 : ER308LSi EN ISO 14343-A : G 19 9 L Si Werkstoffnummer : 1.4316
Approvals	CE EN 13479 DB 43.118.01 VdTUV 00065

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C - High Si
Shielding Gas	M11, M12 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	135 J (100 ft-lb)
As Welded	-196 °C (-321 °F)	50 J (37 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.02	1.7	0.7	0.010	0.020	10.3	19.6	0.02	0.13	0.06

Typical Weld Metal Analysis %

Nb	FN WRC-92
0.01	8

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.013	1.8	0.9	0.011	0.021	10	20	0.2	0.2	0.06

Typical Wire Composition %

Nb	Ti	Co	FN WRC-92
0.01	0.004	0.10	9

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.9 mm (0.035 in.)	65-220 A	15-28 V	3.5-18.0 m/min (138-709 in./min)	1.1-5.4 kg/h (2.4-11. lb/h)

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm (0.030 in.)	40-120 A	15-19 V	4.0-8.0 m/min (157-315 in./min)
1.0 mm (0.040 in.)	60-220 A	15-28 V	4.0-12.0 m/min (157-472 in./min)
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)
1.6 mm (1/16 in.)	230-350 A	25-30 V	3.0-5.0 m/min (118-197 in./min)