



Cromatig 308LSi

GTAW - TIG
Stainless Steel

Date: 2008-01-22
Revision: 11

Description:

Cromatig 308LSi is primarily intended for welding the low carbon 18% Cr / 10% Ni, type 304L, austenitic stainless steels. It is also suitable for stainless steel grade 304 material and the Nb or Ti stabilised grades 347 and 321, provided service temperatures for structural work are below 400°C. The higher silicon content provides a more fluid weld pool which may be preferred for certain welding applications.

Welding current:

DC-

Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,65	1,5			19,5	9,0
Typical	0,02	0,8	1,75	0,02	0,01	20,0	10,0
Max	0,025	1,00	2,0	0,03	0,025	21,0	11,0

	Mo	Cu	N
Min			
Typical	0,10	0,10	0,06
Max	0,30	0,30	

Shielding gas:

Acc. to EN 439:

I1, Ar 99.99%, 6-12 l/min

Stamping

Elga, AWS, Wst, EN, Batch

Ferrite content:

FN 9

Corrosion resistance

Good resistance to general and intergranular corrosion. Also good resistance to oxidising acids and cold reducing acids.

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,015	0,75	1,7	0,02	0,01	20,0	10,5
Max							

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	400 MPa
Tensile Strength, Rm:	≥ 520 MPa	590 MPa
Elongation, A5	≥ 35%	40%
Impact energy, CV:		20°C • 120 J -196°C • 50 J

Classification:

EN ISO 14343 W 19 9 LSi
AWS A5.9 ER308LSi

Approvals:

DB Kennblatt Nr 43.042.12
TÜV
CE

Product data

Diam.mm	Length mm	Product code
1,2	1000	9802-1012
1,6	1000	9802-1016
2,0	1000	9802-1020
2,4	1000	9802-1024
3,2	1000	9802-1032