BÖHLER AWS ER308LSi

Solid wire, high-alloyed, stainless

Classifications

EN ISO 14343-A	EN ISO 14343-B	AWS A5.9	W. No.
G 19 9 L Si	SS308LSi	ER308LSi	1.4316

Characteristics and typical fields of application

GMAW solid wire designed for first class welding, 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 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10

AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 Gr. C9, A320 Gr. B8C or D

Typical analysis of solid wire (wt.-%)

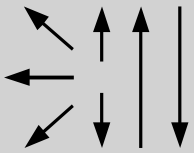
	C	Si	Mn	Cr	Ni
wt.-%	≤0.02	0.8	1.7	20.0	10.2

Mechanical properties of all-weld metal

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
u	**350** (≥ 320)	**540** (≥ 510)	**38** (≥ 35)	**75**	≥ 32

u untreated, as welded – shielding gas Ar + 2.5 % CO_2

Operating data



Polarity:	Shielding gas:	ø (mm) BS300, S300
DC (+)	Argon + max. 2.5 % CO_2	0.8
		0.9
		1.0
		1.2
		1,6

Approvals

TÜV (12936.), DB (43.132.38), CE