

Standards

TS EN ISO 14343-A	: G 19 9 L Si
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AWS A5.9	: ER 308 LSi

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni
0.02	0.8	1.7	20.4	10.2

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
min. 350	520 - 660	min. 63 J	min. 35

Typical Base Material Grades

- X2 CrNi 19 11, X5CrNi 18 10, X6 CrNiTi 18 10, X6 CrNiNb 18 10, X2 CrNiN 18 10, X10 CrNiNb 18 10
- AISI & ASTM: 304, 304L, 304LN, 321, 347, A320Gr.B8C, A320Gr.B8D

Features and Applications

- MIG welding of 13% Cr ferritic stainless steels, high-carbon steels of type 304 or stabilized steels of type 347, or steels of similar types, used in industries of drug, cellulose, paper, and food (production)
- Ar+%2.5O₂ or Ar+%2.5CO₂ mixed gas is used as shielding gas
- Maintenance of ductile behaviour at temperature values down to -196°C.
- Maintenance of resistance to intergranular corrosion at temperatures up to 350°C

Welding Positions



Current Type

MIG D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100323	0.8	0.030"	12.5	BS 300
6011100324	1.0	0.040"	15	BS 300
6011100382	1.2	0.047"	15	BS 300
6011100322	1.6	0.062"	15	BS 300

Approvals: CE, SEPRO