

DATA SHEET N. S10-002

DAIKOWM 308LSi

MIG

Description / Alloy type: Solid wire 308L austenitic stainless steels for 304L base materials.

Specifications: **AWS A5.9** **EN ISO 14343-A** **EN ISO 14343-B**
ER308LSi 19 9 L Si SS308L Si

Approvals: TÜV; CE.

Applications: These consumables are used to weld 18/8 stainless steels.
Mainly applications include food industries, pharmaceutical equipment and general fabrication.
Typical service temperatures are -100°C to 400°C.
The higher silicon content (if compared with standard 308L) increase the welding fluidity and improve the bead appearance.

Materials to be welded: **ASTM:** 304L; 304; 304LN; CF3; CF8; 321; 347.
UNS: S30403; S30400; S30453; S32100; S34700.
EN & DIN: 1.4306; 1.4301; 1.4311; 1.4308; 1.4541; 1.4543/1.4561 1.4550.

Composition:
(weight %)

%	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min	-	1.0	0.65	-	-	19.5	9	-	-	3
Max	0.025	2.0	1.00	0.020	0.030	21.0	11	0.3	0.3	12
Typ	0.010	1.7	0.80	0.010	0.015	20	10	0.1	0.15	10

Typical parameters:

	MIG
Shielding	Ar + 2%O ₂
Current	DC+
Diameter	1.2 mm
Parameters	260A, 26V

All-weld proprieties:

As welded	Typ. MIG
Tensile strength [MPa]	570
Yield strength [MPa]	435
Elongation on 5d [%]	40
Impact Energy -130°C [J]	70

Other products: TIG and SAW wire (AWS A5.9 ER308L)
SMAW electrodes (AWS A5.4 E308L-16 / E308L-15 / E308L-17)
FCAW wire (AWS A5.22 E308LT0-1/4 / E308LT1-1/4)

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