

Lincoln TIG 308LSi

CLASSIFICATION

AWS A5.9 - ER308LSi
ISO 14343-A - W 19 9 L Si

GENERAL DESCRIPTION

**Solid rod with extra low carbon for welding austenitic CrNi-steels
With increased silicon for improved wettability**

SHIELDING GASES (ACC. ISO 14175)

11 Inert gas Ar (100%)

APPROVALS

CE

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo
0.02	2.0	0.8	20	10	0.1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength	Tensile strength	Elongation	Impact ISO-V(J)	
			(N/mm ²)	(N/mm ²)	(%)	+20°C	-196°C
Typical values	11	AW	467	622	37	147	67

MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Extra low carbon (C < 0.03%)					
	X2CrNi19 11		1.4306	(TP)304 L CF-3	S30403 J92500
	X2CrNiN18 10		1.4311	(TP)304LN 302, 304	S30453 S30400
Medium carbon (C > 0.03%)					
	X4CrNi18 10		1.4301 1.4308	(TP)304 CF-8	S30409 J92600
Ti-Nb stabilized					
	X6CrNiTi18 10		1.4541	(TP)321 (TP)321H	S32100 S32109
	X6 CrNiNb 18 10		1.4550 1.4552	(TP)347 CF-8C	S34700 J92710
		GX5 CrNiNb 19 10			

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.2	1.6	2.0	2.4	3.2	Note : Cut length = 1000 mm
Unit : 5 kg tube	X	X	X	X	X	
Other sizes and packaging on request						

Lincoln TIG308LSi: rev. EN 03

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Fumes: Material Safety Data Sheets (MSDS) are available on our website.