

# ER308LSi Solid Stainless Steel Mig Wire

## Description

MIGarc 308LSi is a stainless steel MIG wire with high silicon levels to improve arc characteristics and weld pool fluidity, and flatten weld bead profile. Low carbon increases resistance to corrosion and maintains mechanical properties, it is used for general purpose applications where corrosion conditions are moderate. Used mostly in the industry for welding 304 stainless steel.

## SHIELDING GAS:

98% Argon 2% CO<sub>2</sub>

## CONFORMANCES:

AWS A5.9: ER308LSi  
AS/NZS ISO 14343 B-SS308LSi  
ISO 14343 19 9 L Si

## TYPICAL APPLICATIONS

- 304 and 304L Stainless Steels
- Common austenitic stainless steels referred to as "18-8" steels
- Welding of 301, 302, 321, 347, 409 and 444 type alloys

## WIRE CHEMICAL COMPOSITION wt%

	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
MAX	0.030	1.000	2.500	0.030	0.030	22.00	11.000	0.750	0.750
MIN	-	0.650	1.000	-	-	19.500	9.00	-	-
Typical	0.018	0.780	1.830	0.024	0.020	19.730	10.220	0.060	0.190

## TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield MPa	Tensile Strength MPa	Elongation %	Absorbed Energy (J)	Test Temp (C)
410	570	42	59	-196

## WELDING POSITIONS

All Positional

## CURRENT RANGE DC+ (For Guidance Only)

Diameter	0.9mm	1.0mm	1.2mm
Current Range (A)	130-220	150-240	180-260
Voltage Range (V)	22-25	23-26	24-32
Gas Flow 98%Ar+2%CO <sub>2</sub>	18-20 L/min	18-20 L/min	18-20 L/min