

Descriptions

MIG EQ308LSi is suitable for welding thin plate of 18%Cr-8%Ni stainless steel with high travel speed, such as AISI 301, 302, 304, 304L and 308 steel. Its weld metal is austenite structure with 20%Cr-9%Ni. This product provides good weldability and puddle fluidity. Also with good crack and corrosion resistance due to moderate ferrite content.

Shielding gas: Ar+1-2%O₂ or Ar+1-2%CO₂

Notes on usage:

1. Use Ar blend with 1~2%O₂ for high current spray transfer welding.
2. Use Ar blend with 1~2%CO₂ for low current, short-circuit transfer welding.

Classification

AWS A5.9 ER308LSi

JIS Z3321 YS308LSi

EN ISO 14343-A G199 LSi

Typical Chemical Composition (All Weld Metal), weight %

C	Si	Mn	P	S	Cr	Ni			
0.022	0.85	1.62	0.015	0.008	19.91	10.03			

Mechanical Properties (All Weld Metal, as welded) Shielding gas: Ar+1%O₂

Yield Strength, N/mm ²	400
Tensile Strength, N/mm ²	550
Elongation, %	43
Charpy V-Notch @ 0°C, J	

Operating Data (DC+)

Diameter	Ar+1-2%CO ₂	Ar+1-2%O ₂
0.8 mm	40 – 120	160 – 210
0.9 mm	60 – 140	170 – 260
1.0 mm	80 – 160	180 – 280
1.2 mm	100 – 210	200 – 300
1.4 mm	-	210 – 320
1.6 mm	-	220 – 330