

SUPERMIG 308LSi

MIG (GMAW)

SOLID WIRE FOR MIG

PRODUCT DESCRIPTION

Solid wire for MIG

CLASSIFICATIONS

AWS A5.9M	ER308L Si
ISO 14343-A	G 19 9 L Si
ISO 14343-B	SS308L Si

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 3

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	--	1.0	0.65	--	--	19.5	9.0	--	--	3
Max.	0.025	2.0	1.00	0.020	0.030	21.0	11.0	0.3	0.3	12
Typical	0.01	1.7	0.80	0.01	0.015	20	10	0.1	0.15	10

ALL-WELD MECHANICAL PROPERTIES

As welded	Typical
Tensile strength [MPa]	570
0.2% proof strength [MPa]	435
Elongation (%) 4d	42
5d	40
Impact ISO-V(I) -130°C	70
-196°C *	30-60
Hardness cap/mid [HV]	200/220

* For applications requiring cryogenic toughness see data sheet B-37.

EXAMPLE OF OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Ar+2%O ₂ *	DC+	1.2	260A, 26V

*Also proprietary Ar and Ar-He gas mixtures with < 3%CO₂.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
0.8	15	S300	MER308LSI-08
1.0	15	S300	MER308LSI-10
1.2	15	S300	MER308LSI-12

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr ³	Ni	Mo	Cu	OES (mg/m3)
32	12	16	8	< 0.5	< 0.5	3.1