Lincoln® MIG 308LSi

Key Features

- High silicon level for increased puddle fluidity, better bead shape and edge wetting
- Low carbon wire to resist inter-granular corrosion (weld decay)
- Versatile wire designed to weld Cr-Ni austenitic stainless steels
- Precision layer wound wire assists feeding and resists wire tangles

Typical Applications

- 304 and 304L stainless steels
- Common austenitic stainless steels referred to as "18-8" steels
- Suitable for welding UNS Grades S30403, S30400, S30409, S32100, S32109, S34700

Conformances

AWS A5.9/A5.9M: ER308LSi

Welding Positions

Shielding Gas

- 98-99% Argon / 1-2 % O_2 (spray transfer)
- 98-99% Argon / 1-2% CO_2 (short circuit)
- Flow Rate: 15-20 L/min

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS ipm	Voltage volts	Current amps	CTWD mm
0.8	331088	Spool S300 15kg	120-600	18-22	50-150	10-15
0.9	331089	Spool S300 15kg	120-475	19-23	60-210	10-15
1.2	331082	Spool S300 15kg	125-360	19-25	100-260	15-20

Mechanical Properties - As required per AWS A5.9

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -196°C	FN WRC
Requirements - AWS ER308LSi	Not specified	Not specified	Not specified	Not specified	Not specified
Typical Results	420	570	45	55	8-11

Wire Composition

	%C	%Mn	%Si	%Cr	%Ni
Typical Results	0.02	1.62	0.85	19.9	9.7