

Standards

TS EN ISO 14343-A	: G 19 9 L Si
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AWS A5.9	: ER 308 LSi

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni
0.02	0.8	1.7	20.4	10.2

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
min. 350	520 - 660	min. 63 J	min. 35

Typical Base Material Grades

- X2 CrNi 19 11, X5CrNi 18 10, X6 CrNiTi 18 10, X6 CrNiNb 18 10, X2 CrNiN 18 10, X10 CrNiNb 18 10
- AISI & ASTM: 304, 304L, 304LN, 321, 347, A320Gr.B8C, A320Gr.B8D

Features and Applications

- MIG welding of 13% Cr ferritic stainless steels, high-carbon steels of type 304 or stabilized steels of type 347, or steels of similar types, used in industries of drug, cellulose, paper, and food (production)
- Ar+%2.5O₂ or Ar+%2.5CO₂ mixed gas is used as shielding gas
- Maintenance of ductile behavior at temperature values down to -196°C.
- Maintenance of resistance to intergranular corrosion at temperatures up to 350°C

Welding Positions



Current Type

MIG D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
	mm	inch		
6011100323	0.8	0.030"	12.5	BS 300
6011100324	1.0	0.040"	15	BS 300
6011100382	1.2	0.047"	15	BS 300
6011100322	1.6	0.062"	15	BS 300

Approvals: CE, SEPRO