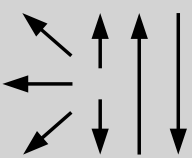


Classifications					
<b>EN ISO 14343-A</b>	<b>EN ISO 14343-B</b>	<b>AWS A5.9</b>	<b>W. No.</b>		
G 19 9 L Si	SS308LSi	ER308LSi	1.4316		
Characteristics and typical fields of application					
GMAW solid wire of type G 19 9 L Si / ER308LSi designed for first class welding, wetting and feeding characteristics and excellent weld metal CVN values down to $-196\text{ }^{\circ}\text{C}$ . Resistance to intergranular corrosion up to $+350\text{ }^{\circ}\text{C}$ .					
Base materials					
1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2CrNi18-10, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10 AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 Gr. C9, A320 Gr. B8C or D					
Typical analysis of solid wire (wt.-%)					
	C	Si	Mn	Cr	Ni
wt.-%	$\leq 0.02$	0.8	1.7	20.0	10.2
Mechanical properties of all-weld metal					
Condition	Yield strength $R_{p0,2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact work ISO-V KV J	
	MPa	MPa	%	$+20\text{ }^{\circ}\text{C}$	$-196\text{ }^{\circ}\text{C}$
u	<b>390</b> ( $\geq 320$ )	<b>540</b> ( $\geq 510$ )	<b>38</b> ( $\geq 35$ )	<b>110</b>	( $\geq 32$ )
u untreated, as welded – shielding gas Ar + 2.5 % $\text{CO}_2$					
Operating data					
	<b>Polarity:</b> DC ( + )	<b>Shielding gas:</b> Argon + max. 2.5 % $\text{CO}_2$	<b>ø (mm)</b>		
			0.8		
			1.0		
			1.2		
Approvals					
TÜV (03159.), DB (43.014.09), DNV (308L), GL (4550S), SEPROZ, CE					

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