

OK Autrod 308LSi

A continuous solid corrosion resisting chromium-nickel wire for welding of austenitic chromium nickel alloys of 18% Cr - 8% Ni-type. OK Autrod 308LSi has a good general corrosion resistance. The alloy has a low carbon content making it particularly recommended where there is a risk of intergranular corrosion. The higher silicon content improves the welding properties, such as wetting. The alloy is widely used in the chemical and food processing industries as well as for pipes, tubes and boilers.

Classifications Wire Electrode	SFA/AWS A5.9 : ER308LSi EN ISO 14343-A : G 19 9 L Si Werkstoffnummer : ~1.4316
Approvals	BV 308L SA BT (M12) CE EN 13479 CWB ER308LSi DB 43.039.01 DNV-GL VL 308 L (M13) NAKS/HAKC 0.8-1.2 mm VdTUV 04267

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C - High Si
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	400 MPa	570 MPa	36 %
Tested at 350°C.			
As Welded	370 MPa	490 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-196 °C	45 J
As Welded	20 °C	110 J
As Welded	-60 °C	70 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.01	1.8	0.8	0.015	0.015	10	20	0.1	0.1

Wire Composition

C	Mn	Si	Ni	Cr	Mo	Cu	Ferrite FN
0.01	1.8	0.9	10.5	19.9	0.15	0.10	9

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.6 mm	-	-	0.0-0.0 m/min	0.0-0.0 kg/h
0.8 mm	55-160 A	15-24 V	4.0-17.0 m/min	1.0-4.1 kg/h
0.9 mm	65-220 A	15-28 V	3.5-18.0 m/min	1.1-5.4 kg/h
1.0 mm	80-240 A	15-28 V	4.0-16.0 m/min	1.5-6.0 kg/h
1.14 mm	-	-	0.0-0.0 m/min	0.0-0.0 kg/h
1.2 mm	100-300 A	15-29 V	3.0-14.0 m/min	1.6-7.5 kg/h
1.6 mm	230-375 A	23-29 V	5.5-9.0 m/min	5.2-8.6 kg/h

Recommended Welding Parameters

Wire Diameter	Wire Feed Speed
0.6 mm	0.0-0.0 m/min
1.14 mm	0.0-0.0 m/min