

PRODUCT DATA SHEET

MIG WIRE - PROWELD - 308LSi/ (1.4316)

Classification: AWS / ASME – A/ SFA 5.9 ER 308LSi
BS EN 14343: 2009 – G19 9 L Si

Approvals: TUV, DB, CWB, CE Marking

Typical Applications:

Proweld 308LSi is primarily used for welding austenitic stainless steel of type 304L/1.4306, 304/1.4301 type. This grade can be used to weld stabilized stainless steel grades like 347,321 for low service temperatures. However it is recommended to use Proweld 347Si for service temperature above 350°C

The higher silicon content gives better arc stability and weld fluidity. However it is recommended to use Proweld 347Si.

Welding Parameters:

Diameter (mm/in.)	Current (A)	Voltage (V)
0.80 / 0.030"	100-160	18-22
1.00 / 0.040"	140-200	18-24
1.20 / 0.045"	170-260	20-28
1.60 / 0.060"	220-350	24-36

Welding parameters such as Current, Voltage are just guidelines to users because it depends on application, section thickness of job, design of joints, arc travel speed etc.

Wire Composition: (%)

	C	Mn	Si	Cr	Ni	S	P	Mo
min	-	1.0	0.65	19.5	9	-	-	-
max	0.03	2.5	1.00	21.0	11	0.02	0.03	0.30

Shielding Gas:

M12 Argon+2% CO₂, 14-20 L/min
M13 Argon+1-3% O₂, 14-20 L/min

Mechanical properties (Typical as Weld):

Tensile Strength	600N/mm ²
Yield Strength	400 N/mm ²
Elongation A5	35%
Impact energy(20° C)	120J
-196°C	50 J
Hardness	190 BHN

Corrosion resistance:

Superior to type 308L, When surfacing on mild steel a corrosion resistance equivalent to ASTM 304 is obtained at the first run.

Packaging Detail:

Diameter : 0.80, 1.00, 1.20 , 1.60 mm *

Packing ** : 12.5Kg (25 lbs), 15Kg (30 – 33lbs)
Layer wound plastic spools i.e. SD300, Metallic basket (K300).
5Kg (10lbs) layer wound plastic spools i.e. SD200.
1Kg (2lbs) layer wound plastic spools i.e. SD100.
Drum pack 100 kgs and 250 kgs (0.80, 1.00, 1.20mm)

*Also available in AWS standard diameters.