

# MI 308LSI

Gazaltı (MIG/MAG) Kaynak Teli - Stainless Steels

| Standards           |            |
|---------------------|------------|
| AWS/ASME SFA - 5.9  | ER308LSi   |
| EN ISO 14343 - A    | G 19 9 LSi |
| TS EN ISO 14343 - A | G 19 9 LSi |
| DIN M. No.          | 1.4316     |

## Properties and Applications

Austenitic stainless steel welding wire for GMA (MIG/MAG) welding of unstabilized or stabilized corrosion resisting Cr-Ni steels tanks, pipes and equipments used in food beverage and pharmaceutical industry. Resistant to intergranular corrosion up to 350°C. Non-scaling up to 800°C, in air or oxidizing combustion gases.

| Materials      |          |           |
|----------------|----------|-----------|
| Width          | Material | ASTM      |
| X5CrNi18-10    | 1.4301   | 304       |
| X4CrNi18-12    | 1.4303   | 305       |
| X2CrNi19-11    | 1.4306   | 304L      |
| GX5CrNi19 10   | 1.4308   | CF-8      |
| X2CrNi18-10    | 1.4311   | 304LN     |
| X6CrNiTi18-10  | 1.4541   | 321       |
| X6CrNiNb18-10  | 1.4550   | 347, 347H |
| GX5CrNiNb19-11 | 1.4552   |           |

## Typical Chemical Features of the Welding Wire

| Type of Analysis | C    | Si   | Mn   | Cr    | Ni   |
|------------------|------|------|------|-------|------|
| Welding Wire     | 0.01 | 0.70 | 1.90 | 20.00 | 9.50 |

## Typical Mechanical Values of Weld Metal

| Test Condition | Protection Gas | Yield Strength (N/mm <sup>2</sup> ) | Tensile Strength (N/mm <sup>2</sup> ) | Elongation A5 (%) | Charpy V-Notch Properties (J) |
|----------------|----------------|-------------------------------------|---------------------------------------|-------------------|-------------------------------|
| As welded      | M13            | 450                                 | 570                                   | 38                | 20°C → 100                    |

\* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M13 (Ar+%0,5-3 O2) .

## Application Information

**Welding Positions**

**Polarity:**

**Protection Gas:**  
M13 M12 M14 I1

**Welding Parameters & Efficiency**

| Diameter (mm) |
|---------------|
| 0.60          |
| 0.80          |
| 1.00          |
| 1.20          |
| 1.60          |

## Packaging Information

| Product Code | Diameter (mm) | Quantity per Box | Box Gross Weight (kg) | Boxes per Outer Box | Outer Box Gross Weight (kg) | Packaging Type             |
|--------------|---------------|------------------|-----------------------|---------------------|-----------------------------|----------------------------|
| 23002AJAM2   | 0.60          | 13 kg            | 13.10                 | 1                   | 13.10                       | Wire Basket Spool (K300MS) |
| 23002BAKM2   | 0.80          | 1 kg             | 1.10                  | 14                  | 15.70                       | Plastic Spool (D100)       |
| 23002BBAM2   | 0.80          | 5 kg             | 5.30                  | 1                   | 5.30                        | Plastic Spool (D200)       |
| 23002BJAM2   | 0.80          | 15 kg            | 15.70                 | 1                   | 15.70                       | Wire Basket Spool (K300MS) |
| 23002DAKM2   | 1.00          | 1 kg             | 1.10                  | 14                  | 15.70                       | Plastic Spool (D100)       |
| 23002DBAM2   | 1.00          | 5 kg             | 5.30                  | 1                   | 5.30                        | Plastic Spool (D200)       |
| 23002DJAM2   | 1.00          | 15 kg            | 15.70                 | 1                   | 15.70                       | Wire Basket Spool (K300MS) |
| 23002E1GM2   | 1.20          | 230 kg           | 0.00                  | 1                   | 0.00                        | Fiber Drum                 |
| 23002EBAM2   | 1.20          | 5 kg             | 5.10                  | 1                   | 5.10                        | Plastic Spool (D200)       |
| 23002EJAM2   | 1.20          | 15 kg            | 15.70                 | 1                   | 15.70                       | Wire Basket Spool (K300MS) |

|            |      |       |       |   |       |                            |
|------------|------|-------|-------|---|-------|----------------------------|
| 23002GJAM2 | 1.60 | 15 kg | 15.70 | 1 | 15.70 | Wire Basket Spool (K300MS) |
|------------|------|-------|-------|---|-------|----------------------------|

**Storage & Re-Drying Information**

Shouldn't be exposed to high statical load and impact.