

## Classifications

<b>EN ISO 14343-A</b>	<b>AWS A5.9 / SFA-5.9</b>
G 19 9 L Si	ER308LSi

## Characteristics and typical fields of application

Solid wire G 19 9 L Si / ER308LSi for joining and surfacing applications with matching and similar austenitic steels and cast steel grades. Good corrosion resistance. High weld metal toughness down to  $-196^{\circ}\text{C}$ . Application temperature max.  $350^{\circ}\text{C}$ .

## Base materials

1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2CrNiN18-10, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10  
AISI 304, 304L, 304LN, 302, 321, 347

## Typical analysis

	C	Si	Mn	Cr	Ni
wt.-%	$\leq 0.02$	0.9	1.7	20	10.2

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact energy ISO-V KV J	
	MPa	MPa	%	$20^{\circ}\text{C}$	$-196^{\circ}\text{C}$
u	390 ( $\geq 320$ )	540 ( $\geq 510$ )	38 ( $\geq 35$ )	110	46 ( $\geq 32$ )

u untreated, as-welded – shielding gas Ar + 2.5%  $\text{CO}_2$

## Operating data

Polarity	DC +	Dimension mm
Shielding gas (EN ISO 14175)	M12, M13	0.8
		1.0
		1.2
		1.6

## Approvals

TÜV (19793), DB (43.132.88), CE