

Gas Metal Arc Welding

JIS Z3321 Y308LSi
AWS A5.9 ER308LSi
DIN 8556-SG 1.4316

MS M-308LSi Solid Wires for Stainless Steel

Applications Suitable for low carbon 18%Cr-8%Ni stainless steel
The arc stability, bead width and blow hole resistibility is good because of high silicon. It can be applied to multi-layer welding.

Brand Name	MS M-308LSi									
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-	-
	≤ 0.030	≤ 0.65	1.0- -1.00	≤ 0.03	≤ 0.03	9.0 - 11.0	19.5 - 22.0	-	-	-
Mechanical property of deposited metal										
Tensile strength	≥ 510 N/mm ²									
0.2% Offset strength	≥ 205 N/mm ²									
Elongation	≥ 35 %									
Impact test	2mm Vnotch Impact value at -196° C 59 J									
Welding position	Horizontal/Flat position									
Welding polarity	DC-EP									
Shielding gas	98%Ar - 2%O ₂									
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6mm					
	80-180A	120-200A	140-250 A	170-300 A	200-350A					
Packing	12.50 kgs standard other packing weight can be provided upon request.									