

CEWELD 308LSi Tig

TYPE High alloyed 308LSi Tig rod for welding CrNi 18/10 types.(1.4316, 19 9 LSi)

APPLICATIONS CEWELD 308LSiTig is for joint and overlay welding on like and similar type austenitic steels/cast steels in the following applications: Boilers, tanks, agriculture, liquid containers, food machinery, furniture..

PROPERTIES Austenitic filler metal for stabilized and non-stabilized CrNi steels. Heat resistant up to 350°C. Excelent toughness properties down to -196°C. Good resistance to nitric acid.

CLASSIFICATION

| | |
|--------|----------------------|
| AWS | A 5.9: ER308LSi |
| EN ISO | 14343-A: W 19 9 L Si |
| W.Nr. | 1.4316 |
| F-nr | 6 |
| FM | 5 |

SUITABLE FOR **ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9%Ni ,TÜV 1000: Gr. 21 - 22 (29 max.350°C),**
 1.4301, 1.4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4546, 1.4550
 X 5 CrNi 18 10, X 2 CrNi 19 11, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10
 AISI 304, 304H, 312, 321H, 347, 347H,
 UNS S30409, S32109, S34709, S30400, S32100, S34700

APPROVALS TÜV: TÜV (12387.00), CE, DB: DB (43.206.02)

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

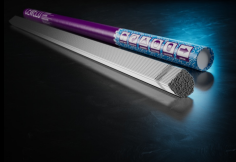
| C | Si | Mn | P | S | Cr | Ni | Mo |
|-------|------|-----|-------|-------|----|----|------|
| 0.016 | 0.75 | 1.9 | 0.015 | 0.012 | 20 | 10 | 0.09 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
| | | | | RT | -196°C | |
| As Welded | 510 | 600 | 37 | 120 | 45 | HRC |

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD 308LSi Tig

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|-------------------------|-----------|---------|---------------|
| 308LSI TIG 0,8 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412294 |
| 308LSI TIG 1,0 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412324 |
| | Tube | 5 | 8720663412300 |
| 308LSI TIG 1,2 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412409 |
| | Tube | 5 | 8720663412331 |
| 308LSI TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412416 |
| 308LSI TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412430 |
| 308LSI TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412454 |
| 308LSI TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412478 |
| 308LSI TIG 4,0 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412485 |