

MIG welding filler metal designed for austenitic stainless steels without molybdenum, type 304, 304L, 321, 347. It is recommended for metal constructions which do not get hotter than 350°C when in operation.

Classification

AWS 5.9 : ER 308L Si
EN ISO 14343-A : G19 9 L Si

Applications

- Only for constructions which do not get hotter than 350°C when in operation.
- Generally used in a low corrosive environment.

Benefits

- Excellent resistance to corrosion.
- good mechanical properties.

Polarity

DC +

Chemical properties

C %	Si %	Mn %	Ni %	Cr %	S % max	P % max	Fe %
0.025	0.90	1.80	10.00	20.50	0.02	0.02	Base

Mechanical properties

Re	Rm	A 5 d	KV +96°C
400 Mpa	600 Mpa	40 %	48 J

Recommendations

Gas protection complies with EN ISO 14175
Argon / CO₂ (2 to 3%) (M12) or Argon / O₂ (1 to 2%) : 12-18 l/min.

Homologation

TÜV, Vd TÜV, DB, CE



S100

S200 - S300

Packaging

weight (kg)	Wire reel type		Wire diameter (mm)			
			Ø 0.6	Ø 0.8	Ø 1.0	Ø 1.2
1	S100	—	—	086616	—	—
5	S200	—	—	086579	086340	—
15	S300	—	—	—	086357	—