

# FILINOX 308LSi

## MIG/MAG solid wires-TIG rods

Stainless and Heat resistant steels

SAF-FRO

FILINOX 308LSi is a G 19 9 LSi/ER 308LSi type solid MAG welding wire, supplied precision layer wound, depositing a low C-19Cr9Ni weld metal. Suitable for use with Ar+2%O<sub>2</sub> or Ar+0.5...5%CO<sub>2</sub> mixed shielding gases.

FILINOX 308LSi is used for welding of 304 and 304L grade stainless steel. The weld metal provides good corrosion resistance to intergranular attack from a range of liquid media. It is used for a wide range of applications including pipework and plate fabrication, vessel production etc.

The low carbon reduces the propensity to intergranular carbide precipitation, which increases the resistance to intergranular corrosion without the use of stabilizers. The increased silicon content results in increased weld pool fluidity to give a smooth deposit appearance.

Stainless steel wire type ER 308L used to weld AISI 304 and 308L stainless steels. The 0.85% Si content gives better weldability and appearance.

Classification	
EN ISO	14343-A: G 19 9 L Si
AWS	A5.9: ER 308LSi

Approvals	
DB	TÜV
●	●

CE

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni
0.020	1.8	0.85	≤ 0.025	≤ 0.020	20	10

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Impact Energy ISO - V (J)	
				20 °C	-120 °C
As Welded	≥ 350	≥ 520	≥ 35	≥ 80	≥ 32

Gas test: 98% Ar+2% O<sub>2</sub>








### Shielding Gas - EN ISO 14175 : M12, M13

### Materials

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4311 (X2CrNi18-10)

AISI 304 - 304L - 302

Storage
Keep dry and avoid condensation

Current condition and welding position						
DC+						
						
PA	PB	PC	PD	PE	PF	PG

### Packaging data

Packaging Type	BS300	S200	S300
Diam(mm) / weight(kg)	15	5	15
0.6	W000282999	W000282997	W000282998
0.8	W000283002	W000283000	W000283001
1.0	W000283007	W000283005	W000283006
1.2	W000283013		