

NST MIG 308LSi

AWS: A5.9 ER308LSi

EN ISO 14343: 2009 19 9 LSi



Solid wire for welding of corrosion resistant materials.

General description:

NST MIG 308LSi is a low-carbon, solid MIG/MAG wire for welding of corrosion resistant materials such as AISI 304, EN 1.4301, EN 1.4307 etc.

Normally, mixed gas Argon/CO₂ or Argon/O₂ are used as the shielding gas.

This ensures a user friendly, stable welding arc with less spatter, a good visual bead appearance and smooth transition to the parent material.

The wire can be used both with or without Pulse-synching.

And it can also be used for welding of Nb- and Ti-stabilized materials (i.e. ASTM 321) when operating

temperature does not exceed 400 °C.

By higher operating temperatures, a Nb-stabilized welding wire is used.

"Purity" is the keyword when welding high alloyed materials.

Impurities in the weld, will cause porosity.

Inter-pass temperature should not exceed 150 °C.

Heat input should not exceed <2.0kJ/mm.

The weld metal will have an Austenitic structure with a low portion of Ferrite (typically 5-9% ferrite).

Welding positions:



Welding current:

DC+

Gas flow:

12-20 l/min.

Chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	
Max 0.03	0.65-1.0	1.0-2.5	Max 0.03	Max 0.02	Max 0.30	9.0-11.0	19.5-21.0	Max 0.30	

Shielding gas:

Shielding gas: Ar+2-3% CO₂, Ar+2% O₂.

Purge gas: Ar.

Typical mechanical properties of all-weld-metal:

Yield and Tensile Strengths				
Yield Mpa(Rp0.2)	Tensile Mpa(Rm)	Elongation %		
410	590	44		

Ferrite content(typical):

WRC	De long	Schaeffler	
13.3FN	15.4%	12.6%	

Packaging information:

1,0mm x 12,5kg D300
1,0mm x 200kg Ø51cm drum
1,2mm x 12,5kg D300
1,2mm x 200kg Ø51cm drum

Approvals:

CE

Reference / date:

NST MIG 308LSi,
English, 04.02.2016.