



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 308LSi

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REASON FOR ISSUE

Min S changed from 0,0050 to 0,005.

GENERAL

Bare corrosion resisting chromium-nickel rods for welding of austenitic chromium nickel alloys of 18% Cr 8% Ni-type.

OK Tigrod 308LSi has a good general corrosion resistance. The alloy has a low carbon content which makes this alloy particularly recommended were there is a risk of intergranular corrosion. The higher silicon content improves the welding properties, such as wetting. The alloy is widely used in the chemical and food processing industries as well as for pipes, tubes and boilers.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C

CLASSIFICATIONS Wire Electrode

EN ISO 14343-A W 19 9 L Si
SFA/AWS A5.9 ER308LSi
Werkstoffnummer ~1.4316

APPROVALS

CE EN 13479
DB 43.039.11
DNV 308L (-196°C)
NAKS/HAKC CZ
VdTÜV 05335

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.01		0.030
Si	0.8	0.65	1.00
Mn	1.8	1.4	2.1
P	0.02		0.030
S	0.01	0.005	0.020
Cr	20	19.5	21.0
Ni	10	9.0	11.0
Mo	0.1		0.5
Cu	0.1		0.5
N			0.110
Others tot			0.50

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	
	Min	Typ
Rp0.2 (MPa)	320	480
Rm (MPa)	510	625
A5 (%)	30	37
at 20°C (J)		170
at -60°C (J)		150
at -110°C (J)		140
at -196°C (J)		75