

Description:

HOBART 308LSi stainless steel solid wire are used to weld Types 201, 302, 304 and 308 stainless steels. It can also be used for joining some dissimilar 300 series steels. 308LSi has higher silicon content improves wetting of the weld metal and potentially higher travel speed compared to standard 308L.

Typical Wire Analysis (wt%)

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
AWS A5.9 ER308LSi	≤0.08	1.0 - 2.5	0.65 - 1.00	≤0.03	≤0.03	9.0 - 11.0	19.5 - 22.0	≤0.75	≤0.75
EN ISO	≤0.03	1.0 - 2.5	0.65 - 1.00	≤0.03	≤0.03	9.0 - 11.0	19.5 - 22.0	≤0.75	≤0.75
Typical value	0.02	1.60	0.73	0.002	0.012	9.20	19.70	0.12	0.11

Typical Mechanical Properties of Weld Metal

	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	DeLong Ferrite / Schaeffler / WRC Number Range	Charpy V-Notch J (ft-lbf)
					Avg. at -320°F (L-196°C)
100% Ar	70,000 psi (486 MPa)	92,000 psi (640 MPa)	40	8-14	24 ft•lbs (32 Joules)
AWS	Not required	Not required	Not required	Not required	Not required

Sizes and Recommended Current Range (DC+)

Diameter (mm)		1.0		1.2	
Weld Position		Flat & Horizontal		Flat & Horizontal	
Amps		140-225	70-210	130-225	75-225
Volts		23-26	14-23	23-28	15-23
Stick-Out (mm)		13-19	10-13	13-19	10-13
Spray Transfer	98% Ar + 2% O ₂ Flow Rate(l/min)	16.5	-	16.5	-
Short-Circuit	90% He - 7-1/2% Ar - 2-1/2% CO ₂ Flow Rate (l/min)	-	11.8	-	11.8

Sizes Available

MIG Wire (mm)	0.9 / 1.0 / 1.2 / 1.6
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