

OK Autrod 308LSi

A continuous solid corrosion resisting chromium-nickel wire for welding of austenitic chromium nickel alloys of 18% Cr - 8% Ni-type. OK Autrod 308LSi has a good general corrosion resistance. The alloy has a low carbon content making it particularly recommended where 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.

Classifications Wire Electrode:	SFA/AWS A5.9:ER308LSi, Werkstoffnummer :~1.4316, EN ISO 14343-A:G 19 9 L Si
Approvals:	CE EN 13479, BV 308L SA BT (M12), CWB: AWS A5.9 ER308LSi, DB 43.039.01, DNV NV 308 L (M13), VdTÜV 04267, NAKS/HAKK 1.0MM-1.2MM

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	400 MPa (58 ksi)	570 MPa (83 ksi)	36 %
Tested at 350\00B0C (662\00B0F).			
As welded	370 MPa (54 ksi)	490 MPa (71 ksi)	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As welded	20 °C (68 °F)	110 J (81 ft-lb)
As welded	-60 °C (-76 °F)	70 J (52 ft-lb)
As welded	-196 °C (-321 °F)	45 J (33 ft-lb)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Ferrite FN
0.01	1.8	0.9	10.5	19.9	0.15	0.10	9

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm (.030 in.)	55-160 A	15-24 V	4.0-17.0 m/min (157-669 in./min)	1.0-4.1 kg/h (2.2-9.0 lb/h)
0.9 mm (.035 in.)	65-220 A	15-28 V	3.5-18.0 m/min (138-709 in./min)	1.1-5.4 kg/h (2.4-11.9 lb/h)
1.0 mm (.040 in.)	80-240 A	15-28 V	4.0-16.0 m/min (157-630 in./min)	1.5-6.0 kg/h (3.3-13.2 lb/h)
1.2 mm (3/64 in.)	100-300 A	15-29 V	3.0-14.0 m/min (118-551 in./min)	1.6-7.5 kg/h (3.5-16.5 lb/h)
1.6 mm (1/16 in.)	230-375 A	23-29 V	5.5-9.0 m/min (216.5-354 in./min)	5.2-8.6 kg/h (11.5-19.0 lb/h)