



Nevatia Steel & Alloys Pvt. Ltd.  
Office : 904,Lodha Supremus,9<sup>th</sup> floor  
Worli, Mumbai ,India - 400018.  
Web:<http://www.nevatiasteel.com>



TD-Stainless Welding wire  
Revision No.: 02  
Date of Issue : 01.11.2019

IATF 16949 , ISO 9001, ISO 14000 and ISO 45001 Certified Company

## Stainless steel welding wire -Technical data

**Product Name :** nevinox<sup>®</sup>MIG308LSi

**Product Specifications :** ER 308LSi

Grade	Equivalent Standards		
	AWS A5.9/5.9M	EN ISO 14343 A	EN ISO 14343 B
ER 308LSi	ER 308LSi	19 9 L Si	308LSi

**Characteristics :** ER308LSi features a higher silicon content which delivers a smooth bead appearance and enhanced wetting action. This wire offers improved resistance to general and intergranular corrosion.

**Application :** ER308LSi is designed for general purpose GMAW welding. It is also suitable for joining 304 for service temperatures up to approximately 660°F. 308LSi provides a smooth weld profile for many GMAW applications involving stainless steel sheet and plate welding.

### Chemical Composition % (Solid wire)

C	Mn	P	S	Si	Cr	Ni	Mo	Cu
0.03	1.30 - 2.10	0.030	0.020	0.65 - 1.00	19.50 - 21.00	9.00 - 11.00	0.30	0.30

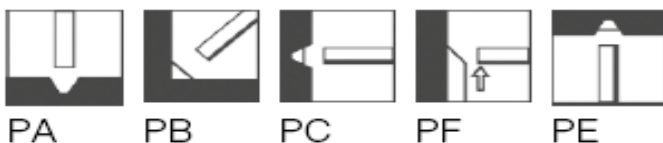
**Remarks:** Single values shown in the table are maximum values. Two values shown indicate minimum and maximum limits for a range.

### Typical All weld Mechanical properties

Product	Grade	Shielding Gas	N/mm <sup>2</sup>		% EL (GL=50mm)	Impact Value (Joules)			
			YS (0.2% PT)	TS		-20°C	-60°C	-101°C	-196°C
MIG	ER 308LSi	M12	419	615	39	-	-	-	53
MIG	ER 308LSi	M21	452	650	39	-	-	-	83

**Current Conditions:-** DC (+)

**Welding position:-**





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### Dimension & Packing Data

Size(mm)	Size(inch)	SD100 Spool packing 1kg/2lb	SD200Spool packing 5kg/10lb	SD300/BS300 Spool packing 12.5kg,15kg /25lb, 33lb	Drum packing 100kg,250kg/ 200lb, -550 lb
0.600	0.024	√	√	-	-
0.800	0.030	√	√	√	√
0.900	0.035	√	√	√	√
1.000	0.040	√	√	√	√
1.200	0.045	√	√	√	√
1.600	0.063	-	√	√	√

### Diameter tolerance and ovality

- As per AWS A5.9 and ISO 544

### Inspection & certification

- As per EN 10204 type 3.1

### Approvals :



For more details please contact : [sales@nevatiasteel.com](mailto:sales@nevatiasteel.com).