

# MWM 308LSi

Stainless Steel MIG Welding Wire – AWS A5.9/ASME SFA-A5.9: ER308LSi

### Key Benefits

- Excellent welding properties and weld bead appearance
- Added Silicon level for increased weld puddle fluidity and toe wetting.
- Low carbon content reducing risk for intergranular corrosion
- Exceptional performance at high wire feed speeds

### Typical applications

- 304 and 304L stainless steels
- Austenitic stainless steels of 18% Cr and 8% Ni grade
- ASTM A743 and A744 Types CF-8 and CF-3

### Conformity and Approvals

AWS A5.9:	ER308Si, ER308LSi
ASME SFA-A5.9:	ER308Si, ER308LSi
CWB/CSA W-48-14:	ER308LSi
EN ISO 14343-B:	SS308LSi
ABS:	E308Si, ER308LSi
ISO 14343-2009	SS308LSi

### Welding Positions

All

### Shielding Gas

98% Ar / Balance O<sub>2</sub>  
Flow rate: 30-50 CFH

### Wire Composition as per AWS A5.9/A5.9M ER308LSi

	%C	%Mn	%Si	%S	%P
<b>Requirements - AWS ER308LSi</b>	0.03 max.	1.0-2.5	0.65-1.00	0.03 max.	0.03 max.
Typical Wire Composition	0.019	1.72	0.86	0.011	0.026
	%Cr	%Ni	%Mo	%Cu	%N <sub>2</sub>
<b>Requirements - AWS ER308LSi</b>	19.5-22.0	9.0-11.0	0.75 max.	0.75 max.	-
Typical Wire Composition	19.64	9.22	0.080	0.005	0.087

### Mechanical Properties as required per AWS A5.9/A5.9M ER308LSi

Typical Results (all weld metal)	Yield Strength	Tensile Strength	Elongation	Impact Energy		FN (WRC-1992)
	MPa (ksi)	MPa (ksi)	%	J	J	
As Welded	470 (68)	640 (93)	34	+20°C	-196°C	10
				140	80	

**Ordering Information**

Article Number	Product	Dimension	Packaging
MWM308LSI061	MWM 308LSi	0.023" (0.6 mm)	1 kg (2.2 lb) plastic spool
MWM308LSI081	MWM 308LSi	0.030" (0.8 mm)	1 kg (2.2 lb) plastic spool
MWM308LSI091	MWM 308LSi	0.035" (0.9 mm)	1 kg (2.2 lb) plastic spool
MWM308LSI121	MWM 308LSi	0.045" (1.2 mm)	1 kg (2.2 lb) plastic spool
MWM308LSI065	MWM 308LSi	0.023" (0.6 mm)	5 kg (11 lb) plastic spool
MWM308LSI085	MWM 308LSi	0.030" (0.8 mm)	5 kg (11 lb) plastic spool
MWM308LSI095	MWM 308LSi	0.035" (0.9 mm)	5 kg (11 lb) plastic spool
MWM308LSI0815	MWM 308LSi	0.030" (0.8 mm)	15 kg (33 lb) plastic spool
MWM308LSI0915	MWM 308LSi	0.035" (0.9 mm)	15 kg (33 lb) plastic spool
MWM308LSI1215	MWM 308LSi	0.045" (1.2 mm)	15 kg (33 lb) plastic spool

