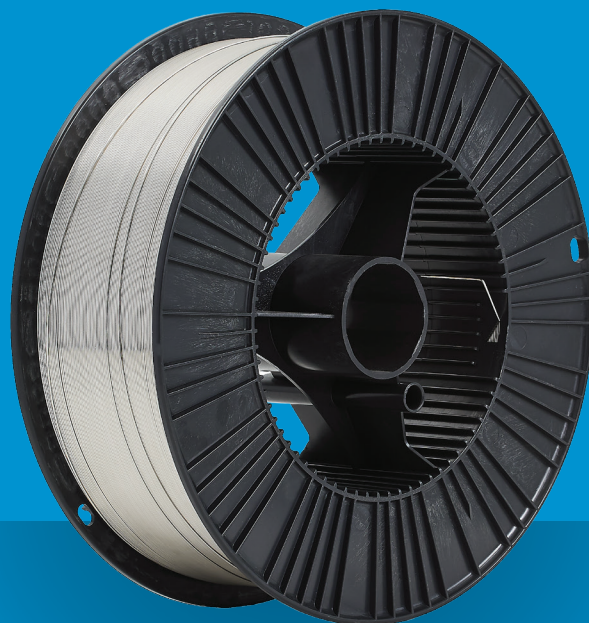


AUTOCRAFT 308LSi

PRODUCT DATA SHEET



**PREMIUM QUALITY, LOW
CARBON 20% CR / 10% NI
STAINLESS STEEL WIRE**



GAS METAL ARC WELDING (MIG) WIRES

AUTOCRAFT 308LSi

- For the GMAW Welding of 18%Cr / 8%Ni Type Stainless Steels.
- Extra Low Carbon (< 0.03%) Weld Deposits for Resistance to Intergranular Corrosion.
- High Silicon level for Improved Arc Stability and Increased Weld Pool Fluidity and Edge Wetting.
- Ultrafeed Matt Finish.

TYPICAL WIRE ANALYSIS:

C:	0.02%
Mn:	2.05%
Si:	0.80%
Cr:	19.95%
Ni:	10.25%
P:	0.020%
S:	0.005%
Fe:	Balance

CLASSIFICATIONS:

ISO AS/NZS 14343:	B SS308LSi
AWS/ASME-SFA A5.9:	ER308LSi

FERRITE NUMBER:

5 – 10 FN

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

ARGON + 1-3% O ₂ :	
0.2% Proof Stress	450 MPa
Tensile Strength	620 MPa
Elongation	36%
CVN Impact Values	90 J av @ -60°C

DESCRIPTION AND APPLICATIONS:

Autocraft 308LSi is a premium quality, low carbon 20% Cr / 10% Ni stainless steel wire for the Gas Metal Arc Welding (GMAW) of a wide range of austenitic 18/8 type stainless steel pipes, plates, forgings and castings.

The low carbon content of Autocraft 308LSi ensures immunity from carbide precipitation and intergranular corrosion when welding low carbon stainless steel grades and the higher Silicon level offers improved arc stability, bead shape and edge wetting.

Autocraft 308LSi is recommended for the general welding of 301, 302, 321, 347, 409 and 444 type stainless steels and for the critical welding of 304 and 304L types in corrosion resistant and cryogenic applications.

COMPARABLE CIGWELD PRODUCTS:

- Satincrome 308L-17 electrode
- AWS A5.4: E308L-17
- Comweld 308L TIG rod
- AWS A5.9: ER308L
- Verti-Cor 308LT FCAW wires
- AWS A5.22: E308LT1-1/4

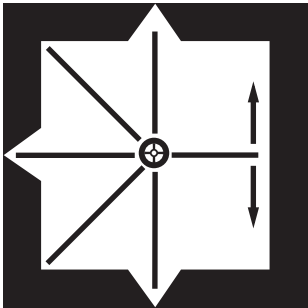
RECOMMENDED* SHIELDING GAS:

AS 4882:	SG-A0-2
	SG-AC-2
	SG-ACH-2/2
	SG-ACHe-2/35
ISO 14175 / AWS A5.32:	M13*- CERT SUPPLIED
	M12
	M11

Ar+O₂ (1-3%) or Ar+CO₂ (2-5%) or Ar+CO₂ (1-4%) +H₂ (1-5%) or Ar+CO₂ (1-4%) +He (35%)

WELDING POSITIONS:

All positional welding applications.



PACKAGING & OPERATING DATA:

These machine settings are a guide only. Actual voltage and welding current used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

WIRE DIAMETER (MM)	VOLTAGE RANGE (VOLTS)	WIRE FEED SPEED (METERS/MIN)	CURRENT RANGE (AMPS)	PACK TYPE*	PACK WEIGHT	PART NO.
0.9	16-24	4.5-15.0	70-200	Spool	15kg	721271
1.2	20-28	3.0-10.0	150-280	Spool	15kg	721272

* Spool (ø300mm).

