



# CEWELD 308LSi Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                         |                      |                    |                         |        |          |     |
|---------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|-----|
| TYPE                                              | High alloyed 308LSi Tig rod for welding CrNi 18/10 types.(1.4316, 19 9 LSi)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |        |          |     |
| APPLICATIONS                                      | CEWELD® 308LSi Tig is for joint and overlay welding on like and similar type austenitic steels/cast steels in the following applications: Boilers, tanks, agriculture, liquid containers, food machinery, furniture..                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                         |                      |                    |                         |        |          |     |
| PROPERTIES                                        | CEWELD® 308LSi Tig is a austenitic filler metal for stabilized and non-stabilized CrNi steels. Heat resistant up to 350°C. Excelent toughness properties down to -196°C. Good resistance to nitric acid.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |        |          |     |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | A 5.9: ER308LSi         |                      |                    |                         |        |          |     |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 14343-A: W 19 9 L Si    |                      |                    |                         |        |          |     |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 1.4316                  |                      |                    |                         |        |          |     |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 6                       |                      |                    |                         |        |          |     |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 5                       |                      |                    |                         |        |          |     |
| SUITABLE FOR                                      | ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9%Ni , TÜV 1000: Gr. 21 - 22 (29 max.350°C),<br>1.4301, 1,4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4543, 1.4546, 1.4550, 1.4561<br>X 5 CrNi 18 10, X 2 CrNi 19 11, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10<br>AISI 302, 303, 304L, 304LN, ~304/304H, 312, 321H, 347, 347H, CF3, CF8,<br>UNS S30409, S32109, S34709, S30400, S32100, S34700                                                                                                                                                                                                     |                         |                      |                    |                         |        |          |     |
| APPROVALS                                         | TÜV: (12387), CE, DB: (43.206.02)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                      |                    |                         |        |          |     |
| WELDING POSITIONS                                 | <div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PE</div> <div> PF</div> <div> PG</div> |                         |                      |                    |                         |        |          |     |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Si                      | Mn                   | P                  | S                       | Cr     | Ni       | Mo  |
|                                                   | 0.016                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 0.75                    | 1.9                  | 0.015              | 0.012                   | 20     | 10       | 0.1 |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |     |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                         |                      |                    | RT                      | -196°C |          |     |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 510                     | 600                  | 37                 | 120                     | 45     | HRc      |     |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                         |                      |                    |                         |        |          |     |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                         |                      |                    |                         |        |          |     |



# CEWELD 308LSi Tig

|                         |           |         |               |
|-------------------------|-----------|---------|---------------|
| 308LSI TIG 0,8 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412294 |
| 308LSI TIG 1,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412324 |
|                         | Tube      | 5       | 8720663412300 |
| 308LSI TIG 1,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412409 |
|                         | Tube      | 5       | 8720663412331 |
| 308LSI TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412416 |
| 308LSI TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412430 |
| 308LSI TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412454 |
| 308LSI TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412478 |
| 308LSI TIG 4,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412485 |