

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.
- ▲ NEW Ultrafeed Matt Finish.

Classifications:

AS 2717.3:	ES308LSi.
AWS/ASME-SFA A5.9:	ER308LSi.

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.

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	

FERRITE NUMBER:

5 – 10 FN

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

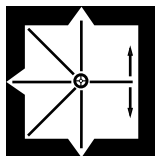
	Ar + 1-3% O ₂ :
0.2% Proof Stress	450 MPa
Tensile Strength	620 MPa
Elongation	36%
CVN Impact Values	90 J av @ -60°C

COMPARABLE CIGWELD PRODUCTS:

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

RECOMMENDED SHIELDING GAS:

- Ar + 1-3% O₂ or equivalent ISO14175: M13
- Ar + 2-5% CO₂ or equivalent ISO14175: M12
- Ar + 1-4% CO₂ + 1-5% H₂ or equivalent ISO14175: M11 (1)
- Ar + 1-4% CO₂ + 35% He



All positional welding applications

Packaging and 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 (metres/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).