

## OK Autrod 308LSi

A continuous solid corrosion resisting chromium-nickel wire for welding of austenitic chromium nickel alloys of 18% Cr - 8% Ni-type. OK Autrod 308LSi has a good general corrosion resistance. The alloy has a low carbon content making it particularly recommended where there is a risk of intergranular corrosion. The higher silicon content improves the welding properties, such as wetting. The alloy is widely used in the chemical and food processing industries as well as for pipes, tubes and boilers.

<b>Classifications Wire Electrode</b>	EN ISO 14343-A: G 19 9 L Si SFA/AWS A5.9: ER308LSi Werkstoffnummer : ~1.4316
<b>Approvals</b>	BV 308L SA BT (M12) CE EN 13479 CWB ER308LSi DB 43.039.01 DNV-GL VL 308 L (M13) NAKS/HAKC 0.8-1.2 mm VdTUV 04267

Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type</b>	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C - High Si
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### Typical Tensile Properties

Yield Strength	Tensile Strength	Elongation
400 MPa (58 ksi)	570 MPa (83 ksi)	36 %
370 MPa (54 ksi)	490 MPa (71 ksi)	25 %
<b>Tested at 350°C (662°F).</b>		
370 MPa (54 ksi)	490 MPa (71 ksi)	25 %

### Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
20 °C (68 °F)	110 J (81 ft-lb)
-60 °C (-76 °F)	70 J (52 ft-lb)
-196 °C (-321 °F)	45 J (33 ft-lb)

### Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Ferrite FN
0.01	1.8	0.9	10.5	19.9	0.15	0.10	9

### Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.6 mm (.023 in.)	-	-	-	-
0.8 mm (.030 in.)	55-160 A	15-24 V	4.0-17.0 m/min (157.5-669 in./min)	1.0-4.1 kg/h (2.2-9.0 lb/h)
0.9 mm (.035 in.)	65-220 A	15-28 V	3.5-18.0 m/min (138-709 in./min)	1.1-5.4 kg/h (2.4-12.0 lb/h)
1.0 mm (.040 in.)	80-240 A	15-28 V	4.0-16.0 m/min (157.5-630 in./min)	1.5-6.0 kg/h (3.3-13.2 lb/h)
1.14 mm (.045 in.)	-	-	-	-
1.2 mm (.045 in.)	100-300 A	15-29 V	3.0-14.0 m/min (118-551 in./min)	1.6-7.5 kg/h (3.5-16.5 lb/h)
1.6 mm (1/16 in.)	230-375 A	23-29 V	5.5-9.0 m/min (216.5-354 in./min)	5.2-8.6 kg/h (11.5-19.0 lb/h)