

KM-308LSi

Classification

Shielding Gas:	Ar+1~2%O ₂	AWS A5.9/A5.9M	ER308LSi
	Ar+1~2%CO ₂	AS/NZS ISO 14343	B SS308LSi

Applications and Features

- (1) Weld metal is austenite structure with 20%Cr-9%Ni.
- (2) Good weldability and puddle fluidity.
- (3) Good crack and corrosion resistance due to moderate ferrite content.
- (4) It is suitable for welding thin plate of 18%Cr-8%Ni stainless steel with high travel speed, such as AISI 301, 302, 304, 304L and 308 steel.

Welding Instruction

- (1) Use Ar blend with 1~2%O₂ for high current spray transfer welding.
- (2) Use Ar blend with 1~2%CO₂ for low current, short-circuit transfer welding. .

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Ni
0.022	0.85	1.62	0.015	0.008	19.91	10.03

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+1% O₂)

Tensile Strength MPa	Yield Strength MPa	Elongation %
550	400	43

Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm)			
		0.8	0.9	1.2	1.6
Ar+1~2%CO ₂	Amp	40~120	60~140	100~210	—
	Volt	15~20	15~21	17~22	—
Ar+1~2%O ₂	Amp	160~210	170~260	200~300	220~330
	Volt	24~28	24~30	24~30	24~32

Diam.	15 kg Spool
0.8mm	KM3080815
0.9mm	KM3080915
1.2mm	KM3081215
1.6mm	KM3081615

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