



## EWB<sup>®</sup> – ER 308LSi MIG / TIG Welding Wires

### Classifications:

EN ISO 14343-A:2007 : W 19 9 L Si  
EN ISO 14343-B:2007 : SS 308LSi  
AWS A5.9: ER308LSi

Material No. 1.4316

### Typical Chemistry Composition of Weld Deposit:

| C     | Cr            | Ni           | Mn          | Si          |
|-------|---------------|--------------|-------------|-------------|
| <0.03 | 19.50 - 22.00 | 9.00 - 11.00 | 1.00 - 2.50 | 0.65 – 1.00 |

### Description:

- MIG / TIG welding of 18%Cr-8%Ni austenite stainless steels (AISI STS 301, 302, 304)

### Typical Mechanical Properties:

| Yield Strength<br>(Mpa) | Tensile Strength<br>(Mpa) | Elongation<br>(%) |
|-------------------------|---------------------------|-------------------|
| min. 320                | min. 520                  | min. 35           |

### Welding Parameters:

|                         |           |           |           |
|-------------------------|-----------|-----------|-----------|
| Wire Diameter (Ø in mm) | 0.80      | 1.00      | 1.20      |
| Pulsed Arc (A)          | 100 - 150 | 120 - 200 | 140 - 220 |
| Voltage (V)             | 22 - 27   | 24 - 28   | 24 - 28   |

### Packing Available:-

**MIG/MAG Wire** (Ø in mm): 0.80 / 1.00 / 1.20

**TIG Wire** (Ø in mm): 1.60 / 2.40 / 3.20 / 4.00

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### EWB Weld

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