EXECUTIVE 308Si/308LSi

STAINLESS STEEL
SOLID WIRE TECHNICAL DATA SHEET

Executive®
FILLER METALS

DESCRIPTION

Executive 308Si/308LSi is a stainless-steel welding wire for TIG and MIG. This wire is used to weld equipment made with 304 and 308 stainless grades. Welding speed is higher than 308 or 308L due to improved wettability of weld metal.

The addition of silicon improves the usability of this alloy in the gas metal arc process producing a more fluid weld and cleaner bead then standard ER308L.

If the dilution by the base metal produces a low ferrite or fully austenitic weld, the crack sensitivity of the weld is somewhat higher than that of a lower silicon content weld metal.

APPLICATIONS & FEATURES

Typically used for 304/304L & 308/308L stainless steel grades this alloy is used in a variety of industries including chemical & food Processing. Executive stainless-steel filler metal is characterized by its clean and consistent finishing which aids in welding.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.013	19.77	9.23	0.12	1.54	0.76	0.025	0.017	0.15

Tensile Strength:	80,000 PSI min	Elongation:	35%	Ferrite Range:	7- 11 FN (WRC-92)
Yield Strength:	59,000 PSI min				

TYPICAL WELDING PARAMETERS

Process		Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW	- Short	.035"	21-22	160-200		
		.045"	22-23	180-210		90% He/7.5% Ar/2.5% CO_2
		.062"	23-24	200-220	30 to 50 CFH	or
	- Spray	.035"	23-25	190-260		1%-5% O_2/Balance Ar
		.045"	25-28	250-330		
		.062"	28-31	310-350		
GTAW		.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW		.093"	29-32	300-350		Record IND 24 or Record IN
		.125"	29-32	400-550		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet

CLASSIFICATION

AWS/SFA 5.9, Class **ER308Si/308LSi**
Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.

1-24