MIG 20/10S

Old reference: MIG 308LSi

Classification

ISO 14343-A : G 19 9 L Si
AWS A5.9 : ER308L Si

Material N° : 1.4316

Description & Applications

Solid low carbon wire for joining of stainless steels (304L, 304, 347, 321…).

Main applications: For construction with service temperature lower than 350°C.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.015	0.9	1.8	20.0	10.0	0.1	0.08	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
400	600	38	+20°C 110 -196°C 50

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8 1.0 1.2 1.6	100-150 120-200 140-220 180-260	22-27 24-28 24-28 24-30	Ar + 2%CO_2 Ar + 1%O_2 18-20 l/min

Ind.10

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