

## Exaton 19.9.LSi

19.9.LSi is a filler metal particularly suited for MIG/MAG welding. It is suitable for joining stainless steels of the 18Cr/8Ni ELC-type and 18Cr/8Ni/Nb type for service temperatures up to 350°C (660°F).

<b>Classifications Wire Electrode</b>	SFA/AWS A5.9 : ER308LSi EN ISO 14343-A : G 19.9 L Si Werkstoffnummer : 1.4316
<b>Approvals</b>	CE EN 13479 DB 43.118.01 VdTUV 00065

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			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	390 MPa	600 MPa	42 %
As Welded	290 MPa	440 MPa	24 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	20 °C	135 J
As Welded	-196 °C	50 J

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.02	1.7	0.7	0.010	0.020	10.3	19.6	0.02	0.13	0.06

Typical Weld Metal Analysis %	
Nb	FN WRC-92
0.01	8

Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.013	1.8	0.9	0.011	0.021	10	20	0.2	0.2	0.06

Typical Wire Composition %			
Nb	Ti	Co	FN WRC-92
0.01	0.004	0.10	9

Recommended Welding Parameters			
Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm	40-120 A	15-19 V	4.0-8.0 m/min
1.0 mm	60-220 A	15-28 V	4.0-12.0 m/min
1.2 mm	150-260 A	24-29 V	3.0-10.0 m/min
1.6 mm	230-350 A	25-30 V	3.0-5.0 m/min