

308L HiSi



AWS A5.9: ER308LSi

DESCRIPTION:

308L HiSi is a stainless steel solid wire with 308L chemistry that has been modified to offer a higher silicon level for increasing weld puddle fluidity, as well as for ensuring tie-ins and potentially higher welding speeds.

TYPICAL WIRE ANALYSIS:

Weld Metal Analysis (%)		AWS Spec
Carbon (C)	0.02	0.03 max
Manganese (Mn)	1.60	1.0 to 2.5
Phosphorus (P)	0.002	0.03 max
Silicon (Si)	0.80	0.65 to 1.00
Copper (Cu)	0.19	0.75 max
Chromium (Cr)	20.00	19.5 to 22.0
Nickel (Ni)	10.00	9.0 to 11.0
Molybdenum (Mo)	0.30	0.75 max
Iron (Fe)	Bal.	Bal.

TYPICAL MECHANICAL PROPERTIES* (As Welded):

Mechanical Tests		AWS Spec
Tensile Strength	86,000 psi (593 MPa)	Not required
Yield Strength	57,000 psi (393 MPa)	Not required
Elongation % in 2" (50 mm)	42%	Not required
DeLong Ferrite Number Range	7-17	Not required
Schaeffler Number Range	7-17	Not required
WRC Number Range (1992)	7-17	Not required

TYPICAL CHARPY V-NOTCH IMPACT VALUES*:

CVN Temperatures		AWS Spec
Avg. at room temperature	92 ft•lbs (125 Joules)	Not required
Avg. at -320°F (-196°C)	33 ft•lbs (45 Joules)	Not required

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the AWS A5.9 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers Company.

308L HiSi

For Spray Transfer Welding with Bare Stainless Wire

Diameter Inches (mm)	Weld Position	Type of Current	Amps	Volts	Wire Feed Speed	Stick-Out Inches (mm)	98% Ar + 2% O ₂ Flow Rate cfh (l/min)
0.030 (0.8)	Flat & Horizontal	DCEP	130-200	23-27	300-600	3/8-1/2 (10-13)	35 (16.5)
0.035 (0.9)	Flat & Horizontal	DCEP	150-225	23-26	375-640	1/2-3/4 (13-19)	35 (16.5)
0.045 (1.2)	Flat & Horizontal	DCEP	200-325	24-28	230-625	1/2-3/4 (13-19)	35 (16.5)
0.052 (1.4)	Flat & Horizontal	DCEP	250-350	24-27	200-400	1/2-3/4 (13-19)	35 (16.5)
1/16 (1.6)	Flat & Horizontal	DCEP	300-350	24-27	250-260	1/2-3/4 (13-19)	35 (16.5)

For Short-Circuit Welding with Bare Stainless Wire

Diameter Inches (mm)	Weld Position	Type of Current	Amps	Volts	Wire Feed Speed	Stick-Out Inches (mm)	90% He - 7-1/2% Ar - 2-1/2% CO ₂ cfh (l/min)
0.030 (0.8)	Flat & Horizontal	DCEP	50-150	17-20	115-525	3/8-1/2 (10-13)	25 (11.8)
0.035 (0.9)	Flat & Horizontal	DCEP	60-200	14-22	130-660	3/8-1/2 (10-13)	25 (11.8)
0.045 (1.2)	Flat & Horizontal	DCEP	75-225	15-23	75-400	3/8-1/2 (10-13)	25 (11.8)
0.052 (1.4)	Flat & Horizontal	DCEP	100-250	16-23	75-300	3/8-1/2 (10-13)	25 (11.8)
1/16 (1.6)	Flat & Horizontal	DCEP	100-250	16-23	75-200	3/8-1/2 (10-13)	25 (11.8)

AVAILABLE DIAMETERS AND PACKAGES: (Spooled and Coiled)

Diameter Inches (mm)	30-Lb. (14kg) Spool	550-Lb. (250kg) Drum
Net Pallet weight	2160-lb (980 kg)	2200-lb (1000 kg)
0.030 (0.8)	S526806-I26	—
0.035 (0.9)	S526808-I26	S526808-550
0.045 (1.2)	S526812-I26	S526812-550
0.052 (1.4)	S526815-I26	S526815-550
1/16 (0.9)	S526818-I26	—

CONFORMANCES AND APPROVALS:

- AWS A5.9, Class ER308LSi
- ASME SFA 5.9
- CWB, ER308LSi
- ABS, ER308LSi 98% Ar, 2% O₂, all position, DCEP (0.8 mm - 1.6 mm)

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

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