

# Stainless Steel MIG Wire

**GM308LSi/GT308LSi**

AWS A5.9 ER308LSi  
JIS Z 3321 YS308LSi  
ISO 14343-A-G 19 9 L Si  
14343-A-W 19 9 L Si

## Product Features:

- Low carbon content in weld metal to get good inter-granular corrosion resistance.
- High silicon content with good bead appearance and better wettability.

## Applications:

- Suitable for welding of low carbon content 18%Cr-8%Ni stainless steel (SUS304 or SUS 304L).

## Shielding gas:

- Ar+ 1~2% O<sub>2</sub> (MIG)

Typical chemical composition of wire (wt%)

| C     | Si   | Mn   | Ni   | Cr    | Mo   |
|-------|------|------|------|-------|------|
| 0.009 | 0.91 | 1.54 | 9.65 | 19.51 | 0.13 |

Typical mechanical properties of all weld metal

| Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>% | Impact value<br>(-196°C) J |
|---------------------------------------|-----------------|----------------------------|
| 600                                   | 43              | 46                         |

Wire size & recommended welding parameters ; DC+

| Diameter (mm)       | 0.9/1.0 | 1.2    | 1.6     |
|---------------------|---------|--------|---------|
| Current range (Amp) | 70~200  | 90~250 | 200~300 |

TIG rod size diameter/length; DC-

| Diameter (mm) | 1.6  | 2.0  | 2.4/2.6 | 3.2  |
|---------------|------|------|---------|------|
| Length (mm)   | 1000 | 1000 | 1000    | 1000 |

## Note:

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