

Welding wire for stainless steel MIG/MAG - T08M

EN ISO 14343-A: G 19 9 LSi
DIN 8556 SG - X5 CrNi 19 9
AWS A-5.9: ER308LSi

This austenitic wire with very low content of carbon is intended for welding of corrosion-proof steel containing approximately 18% Cr and 8% Ni. Increased content of Si improves its weldability. It can be used in constructions of chemical and food industry.

Approvals:

TÜV*
DB 43.244.06

* Certificate is pending

Welded material:

1.4301, 1.4306, 1.4550 etc.

Shielding gas (EN ISO 14175):

M13, M12

Welding current:

=(+)

Welding positions:



Product no

ø mm	1 kg	5 kg	15 kg
0,6	T08M.024	T08M.025	-
0,8	T08M.026	T08M.027	T08M.028
1,0	-	T08M.029	T08M.030
1,2	-	T08M.031	T08M.032

Typical Chemical composition of the weld metal (%)

C	Si	Mn	Cr	Ni
<0,03	0,80	1,80	20,0	10,0

Typical mechanical properties of the weld metal

Test method	Condition	Gas	Test temperature °C	R _m MPa	R _{p0,2} MPa	A ₅ %	KV (J)/°C		
							+20	-60	-196
EN	TZ0	M13	+20	620	370	36	110	90	60
EN	TZ0	M13	+350	490	370	25			
EN	A	M13	+20	600	340	43	90	80	60
EN	A	M13	+350	460	240	28			

TZ0 - after welding, A - heat treatment 1050 °C/10,5h

Technological parameters

ø d	Welding current	Arc voltage	Gas flow rate	Feed speed	Weld metal efficiency
(mm)	(A)	(V)	(l/min)	(m/min)	(kg/h)
0,8	55 - 160	15 - 24	12	4,0 - 17,0	1,0 - 4,1
1,0	80 - 240	15 - 28	15	4,0 - 16,0	1,5 - 6,0
1,2	100 - 300	15 - 29	18	3,0 - 14,0	1,6 - 7,5