

INERTROD 308LSi is a W 19 9 LSi/ER 308LSi type solid TIG welding rod depositing a low C-19Cr 9 Ni weld metal. Suitable for use mainly with Ar shielding gas.

INERTROD 308LSi is used for welding of 304 and 304L grade stainless steel. The weld metal has good corrosion resistance properties, including intergranular attack from a range of liquid media at service temperature <300°C. It is used for a wide range of applications including pipework and plate fabrication, vessel production etc.

Low carbon reduces the possibility to intergranular carbide precipitation, which increases the resistance to intergranular corrosion without the use of stabilizers. The increased silicon promotes weld pool fluidity and a smoother weld deposit appearance.

Classification	
EN ISO	14343-A: W 19 9 L Si
AWS	A5.9: ER 308LSi

Approvals	Grade
DB	●
TÜV	●

CE

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni
0.020	1.8	0.85	≤ 0.025	≤ 0.020	20	10

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-120 °C
As Welded	≥ 350	≥ 520	≥ 35	≥ 80	≥ 40

Gas test: 100% Ar

**Shielding Gas** - EN ISO 14175 : I1

### Materials

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4311 (X2CrNiN18-10)

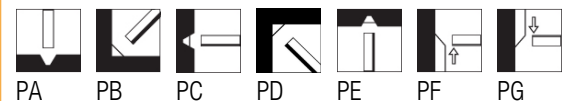
AISI 304 - 304L - 302

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC-



### Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	●
2.0	TUB	5	●
2.4	TUB	5	●