

# Solid Wire Rod for TIG Welding

## BA-TIG 308LSi

**Classification:** EN ISO 14343-A: **W 19 9 L Si**  
SFA-5.9: **ER308LSi**

### Main Application:

BA-TIG 308LSi is a solid wire rod for GTAW with higher Si content than BA-TIG 308L suitable for welding 18% Cr – 10% Ni austenitic stainless steels 1.4301, 1.4306 type 304, 304L. Suitable for service temperature from -196 °C to +350 °C.

### Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9:

(Weight Percent)

Wire rod	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-TIG 308LSi	0.02	0.85	1.8	0.1	10.0	20.0	0.020	0.013	0.1
W 19 9 L Si acc. To ISO 14343-A	0.03	0.65-1.2	1.0-2.5	0.3	9.0-11.0	19.0- 21.0	0.03	0.02	0.3
ER308LSi acc. to AWS A5.9	0.03	0.65-1.0	1.0-2.5	0.75	9.0-11.0	19.5- 22.0	0.03	0.03	0.75

Also available BA-TIG 308LF with low ferrite content.

### All - Weld Metal Mechanical Properties / Welding Data:

Heat Treatment	As Welded
Yield Strength Re, N/mm <sup>2</sup> (ksi)	320 (46)
Tensile Strength Rm, N/mm <sup>2</sup> (ksi)	550 - 650 (80-94)
Elongation A5 [%]	>30
Impact Energy ISO-V, J (ft lbs)	+20°C: 120 (88)
Current/polarity	DC -
Shielding Gas	ISO 14175: I1

### Base Materials:

1.4306/X2CrNi19-11, 1.4301/X5CrNi18-10, 1.4311/ X2CrNi18-10, 1.4312/ GX10CrNi18-8, 1.4541/ X6CrNiTi18-10, 1.4546/ X5CrNiNb18-10, 1.4550/ X6CrNiNb18-10 AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 Gr. C9; A320 Gr. B8C or D.

### Package Forms:

5 kg carton boxes as standard package form for GTAW wire rods.

### Diameter:

1,0 – 3,2 mm. Sizes and tolerances acc. to ISO 544 and AWS A5.9.

### Wire Rod Surface:

Smooth finish free from surface defects and foreign matter.