

# 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<br>°C | R <sub>m</sub><br>MPa | R <sub>p0,2</sub><br>MPa | A <sub>5</sub><br>% | 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             |