

## OK Tigrod 308LSi

Bare corrosion resisting chromium-nickel rods for welding of austenitic chromium nickel alloys of 18% Cr 8% Ni-type. OK Tigrod 308LSi has a good general corrosion resistance. The alloy has a low carbon content which makes this alloy particularly recommended where there is a risk of intergranular corrosion. The higher silicon content improves the welding properties, such as wetting. The alloy is widely used in the chemical and food processing industries as well as for pipes, tubes and boilers.

Specifications	
<b>Classifications</b>	EN ISO 14343-A : W 19 9 L Si SFA/AWS A5.9 : ER308LSi Werkstoffnummer : ~1.4316
<b>Approvals</b>	BV : 308L BT CE : EN 13479 DB : 43.039.11 DNV : NV 308 L UKCA : EN 13479 VdTÜV : 05335

Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type</b>	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C
<b>Shielding Gas</b>	I1 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	480 MPa ( 70 ksi )	635 MPa ( 92 ksi )	37 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C ( 68 °F )	170 J ( 125 ft-lb )
-60 °C ( -76 °F )	150 J ( 111 ft-lb )
-110 °C ( -166 °F )	140 J ( 103 ft-lb )
-196 °C ( -321 °F )	75 J ( 55 ft-lb )

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.8	0.7	0.01	0.02	10	20	0.1	0.1	0.07

Typical Weld Metal Analysis %	
Nb	FN WRC-92
0.1	8

Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.8	0.8	0.012	0.013	10.0	20.0	0.1	0.10	0.06

Typical Wire Composition %	
Nb	FN WRC-92
0.02	8