

GEN 308LHS Welding Wire and Rod

GEN 308LHS has the same chemical composition as GEN 308, except the higher silicon content. It is suitable for welding stainless steel type 304 and 308. Welding process can be done at a higher speed than GEN 308 and GEN 308L due to improved wettability of weld metal. The higher silicon content also provides better arc stability along with smoother bead appearance.

CONFORMANCES

AWS A5.9/A5.9M	:	ER308LSi
ASME SFA-A5.9	:	ER308LSi
ISO 14343B	:	SS308LSi

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%Mn
0.03 max	19.5 – 22.0	9.0 – 11.0	0.75 max	1.0 – 2.5
%Si	%P	%S	%Cu	Total Others
0.65 – 1.00	0.03 max	0.03 max	0.75 max	0.50 max

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength	:	59,000 psi
Tensile Strength	:	87,000 psi
Elongation	:	40 %

TYPICAL WELDING PARAMETERS

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 18	80 – 150	100% Ar
	3/32"	2.4 mm	15 – 20	150 – 250	100% Ar
	1/8"	3.2 mm	16 – 20	200 – 375	100% Ar
MIG (GMAW)	.035"	0.9 mm	23 – 29	170 – 290	98%Ar – 2%O ₂
	.045"	1.1 mm	24 – 30	200 – 360	98%Ar – 2%O ₂
Sub Arc (SAW)	.093"	2.4 mm	28 – 32	250 – 450	
	.125"	3.2 mm	29 – 34	300 – 500	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED
BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

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