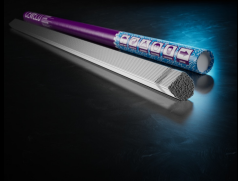




# CEWELD 308LSi Tig

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                            |                         |           |                         |        |          |     |
|------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|-------------------------|-----------|-------------------------|--------|----------|-----|
| TYPE                                                 | Fil de soudage inox 308 LSi pour le soudage de l'inox type CrNi 18/10 - 304L                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                            |                         |           |                         |        |          |     |
| APPLICATIONS                                         | Chaudières, agriculture, réservoirs de stockage de liquides, machines alimentaires, meubles                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                            |                         |           |                         |        |          |     |
| PROPRIÉTÉS                                           | Métal d'apport austénitique pour les aciers CrNi stabilisés et non stabilisés. Résistant à la chaleur jusqu'à 350°C. Excellentes propriétés de ténacité jusqu'à -196°C.                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                            |                         |           |                         |        |          |     |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | A 5.9: ER308LSi            |                         |           |                         |        |          |     |
|                                                      | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 14343-A: W 19 9 L Si       |                         |           |                         |        |          |     |
|                                                      | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 1.4316                     |                         |           |                         |        |          |     |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 6                          |                         |           |                         |        |          |     |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 5                          |                         |           |                         |        |          |     |
| CONVIENT POUR                                        | ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9%Ni , TÜV 1000: Gr. 21 - 22 (29 max.350°C),<br>1.4301, 1.4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4543, 1.4546, 1.4550, 1.4561<br>X 5 CrNi 18 10, X 2 CrNi 19 11, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10<br>AISI 302, 303, 304L, 304LN, ~304/304H, 312, 321H, 347, 347H, CF3, CF8,<br>UNS S30409, S32109, S34709, S30400, S32100, S34700                                                                                                               |                            |                         |           |                         |        |          |     |
| AGRÉMENTS                                            | TÜV: (12387), CE, DB: (43.206.02)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                            |                         |           |                         |        |          |     |
| POSITIONS DE SOUDAGE                                 | <div>PAPBPCPDPEPFPG</div> |                            |                         |           |                         |        |          |     |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Si                         | Mn                      | P         | S                       | Cr     | Ni       | Mo  |
|                                                      | 0.016                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.75                       | 1.9                     | 0.015     | 0.012                   | 20     | 10       | 0.1 |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Impact Energy (J) ISO-V |        | Hardness |     |
|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                            |                         |           | RT                      | -196°C |          |     |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 510                        | 600                     | 37        | 120                     | 45     | HRc      |     |
| ETUVAGE                                              | non nécessaire                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                            |                         |           |                         |        |          |     |
| GAS ACC. EN ISO 14175                                | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                            |                         |           |                         |        |          |     |



# CEWELD 308LSi Tig

|                         |           |         |               |
|-------------------------|-----------|---------|---------------|
| 308LSI TIG 0,8 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412294 |
| 308LSI TIG 1,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412324 |
|                         | Tube      | 5       | 8720663412300 |
| 308LSI TIG 1,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412409 |
|                         | Tube      | 5       | 8720663412331 |
| 308LSI TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412416 |
| 308LSI TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412430 |
| 308LSI TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412454 |
| 308LSI TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412478 |
| 308LSI TIG 4,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663412485 |