



## DESCRIPTION

Solid GMAW (MIG) stainless steel wire with **very low carbon and high silicon content, certified by CWB (Canadian Welding Bureau)**, for welding a wide range of stainless steel grades (301, 302, 304, 304L, 308, 308L, 309, 309L, 316, 316L, 317, 317L, 318, 321, 347, etc.)

## CHARACTERISTICS

- Certified by CWB to CSA W48-06
- Conforms to specifications : AWS A5.9 and ASME SFA 5.9
- Excellent weldability characteristics
- Stable arc with low spatter
- High deposit rate
- Low carbon filler metal

## MECHANICAL PROPERTIES

Selectarc MIG 308LSi : Tensile strength = 87 000 psi (600 MPa) ; Elongation = 38 %

Selectarc MIG 309LSi : Tensile strength = 87 000 psi (600 MPa) ; Elongation = 35 %

Selectarc MIG 316LSi : Tensile strength = 89 900 psi (620 MPa) ; Elongation = 35 %

## WELDING SPECIFICATIONS

Selectarc MIG 308LSi = welding of stainless steel grades 301, 302, 304L, 308, 308L, 321 and 347

Selectarc MIG 309LSi = welding of stainless steel grades 309, 309L, 304, 304L, 308 and 308L

Selectarc MIG 316LSi = welding of stainless steel grades 316, 316L, 317, 317L and 318

## WELDING PARAMETRES

Gas : 98% Ar – 2% CO<sub>2</sub> mixture

Diameter :	0.8 mm .030"	0.9 mm .035"	1.2 mm .045"
Amperage	100 – 150 A	120 – 200 A	140 – 220 A
Voltage	22 – 27 V	24 – 28 V	24 – 28 V
Stick-out	1/2"	1/2"	1/2"
Gaz (pch)	35 - 45	35 - 45	35 - 45

Complete range of stainless steel electrodes certified CWB

TIG rods certified CWB : Selectarc TIG 308L, Selectarc TIG 309L and Selectarc TIG 316L

Flux-cored wire with slag AP (all position) : FC 308L-AP, FC 309L-AP, FC 316L-AP

Flux-cored wire with slag FP (flat and horizontal) : FC 308L-FP, FC 309L-FP, FC 316L-FP

Other stainless steel grades available on request

Rév.: 21\_08

*Specialized welding alloys and technology. For technical assistance or for ordering:*