

Artikelnummer	Omschrijving
00900001	MIG 308LSi werk. nr. 1.4316 0,8mm Hyundai
00900002	MIG 308LSi werk. nr. 1.4316 1,0mm Hyundai
00900003	MIG 308LSi werk. nr. 1.4316 1,2mm Hyundai

SM-308LSi	AWS A5.9 / ASME SFA5.9 ER308LSi JIS Z3321 YS308LSi EN ISO 14343-A G 19 9L Si
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Toepassingen

Voor het lassen van 304 inox staal.

Characteristics on Usage

SM-308LSi is an austenitic type stainless steel wire, the weld metal contains ferrite and crack sensitivity is extremely good. The Usability, such as arc stability and assimilability of welds to base metal is extremely excellent.

Resistance to corrosion and mechanical properties of weld metal are great.

Typical Chemical Composition of Wire (%)

C	Si	Mn	Cr	Ni	Mo
0.027	0.79	1.96	20.78	10.02	0.1

Typical Mechanical properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
610 (88,500)	40.4

Typical Welding Conditions (DC+)

Size mm(in)	A	V	Speed (cm/min.)	Gas Flow (l /min.)	Remarks
1.2	250	26	30	25	100%Ar or Ar+2~5%O ₂
1.6	300	29	35		

Artikelnummer	Omschrijving
00900004	MIG 316LSi werk. nr. 1.4430 0,8mm Hyundai
00900005	MIG 316LSi werk. nr. 1.4430 1,0mm Hyundai
00900006	MIG 316LSi werk. nr. 1.4430 1,2mm Hyundai

SM-316LSi	AWS A5.9 / ASME SFA5.9 ER316LSi JIS Z3321 YS316LSi EN ISO 14343-A G 19 12 3L Si
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Toepassingen

Voor het lassen van 316 inox platen en constructies zoals de voedingsindustrie en chemische industrie. Corrosie weerstand is uitstekend.

Characteristics on Usage

SM-316LSi is an austenitic type stainless steel wire , the weld metal contains ferrite and crack sensitivity is extremely good. The Usability, such as arc stability and assimilability of welds to base metal is extremely excellent. The high silicon content of wire improves the welding properties, such as arc stability and bead wetting. Resistance to corrosion and mechanical properties of weld metal are great.

GMW

Typical Chemical Composition of Wire (%)

C	Si	Mn	Cr	Ni	Mo
0.030	0.65	2.36	19.76	11.62	2.50

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
597 (86,600)	37

Typical Welding Conditions (DC+)

Size mm(in)	A	V	Speed (cm/min.)	Gas Flow (ℓ /min.)	Remarks
1.2 (.045)	250	26	30	25	Shielding gas
1.6 (1/16)	300	29	35		100%Ar or Ar+2%O ₂

Artikelnummer	Omschrijving
00900007	MIG 309LSi werk. nr. 1.4432 0,8mm Hyundai
00900008	MIG 309LSi werk. nr. 1.4432 1,0mm Hyundai
00900009	MIG 309LSi werk. nr. 1.4432 1,2mm Hyundai

SM-309LSi	AWS A5.9 / ASME SFA5.9 ER309LSi JIS Z3321 YS308LSi EN ISO 14343-A G 23 12L Si
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Toepassingen

Voor het lassen van zwart-wit verbindingen (staal - inox). Goede scheurvastheid en corrosie weerstand. Er kan zowel ferritisch als martensitisch roestvrij staal mee gelast worden.

Characteristics on Usage

SM-309LSi is an austenitic type stainless steel wire, the weld metal contains ferrite and crack sensitivity is extremely good. The Usability, such as arc stability and assimilability of welds to base metal is extremely excellent. The high silicon content of wire improves the welding properties, such as arc stability and bead wetting. Resistance to corrosion and mechanical properties of weld metal are great.

GMAW

Typical Chemical Composition of Wire (%)

C	Si	Mn	Cr	Ni	Mo
0.022	0.79	1.61	24.11	13.97	0.1

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
571 (82,800)	40.2

Typical Welding Conditions (DC+)

Size mm(in)	A	V	Speed (cm/min.)	Gas Flow (ℓ /min.)	Remarks
1.2 (.045)	250	26	30	25	Shielding gas 100%Ar or Ar+2%O ₂
1.6 (1/16)	300	29	35		

Artikelnummer	Omschrijving
00900010	MIG 307Si werk. nr. 1.4370 0,8mm Hyundai
00900011	MIG 307Si werk. nr. 1.4370 1,0mm Hyundai
00900012	MIG 307Si werk. nr. 1.4370 1,2mm Hyundai
00900013	MIG 307Si werk. nr. 1.4370 1,6mm Hyundai

SM-307Si
EN ISO 14343-A G 18 8 Mn

Toepassingen

Voor het lassen van bufferlagen en moeilijk lasbare staalsoorten met een hoog koolstofgehalte. Met deze lasdraad verkrijgt u een goede rek en wordt gebruikt als onderlaag bij oplassingen.

Characteristics on Usage

- ① Though SM-307Si is a austenite type stainless wire, the weld metal contains ferrite and resistance to crack is extremely good. The usability, such as arc stability and assimilability of welds to base metal is extremely good.
- ② Resistance to corrosion and the mechanical properties of the weld metal are good.

GMAW

Typical Chemical Composition of Wire (%)

C	Si	Mn	Cr	Ni	Mo
0.08	0.87	7.17	19.6	9.3	0.12

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)	PWHT
610 (88,600)	42	0 (32) -20 (-4)	83 (63) 59 (43)	690°C × 1Hr

Typical Welding Conditions (Pulse)

Dia (mm)	Amp (A)	Vol (V)	Cpm (cm/min)	Gas Flow (ℓ /min)	Shielding Gas
1.2	250	26	30	25	100% Ar or
1.6	300	29	35		Ar +2%O ₂