



# HILCO HILCHROME G308LSi

MAG wires – stainless steel – acid resistant

AWS A5.9: ER 308LSi

EN ISO 14343-A: G 19 9 L Si

Werkstoffnr. 1.4316

**Wire type:**  
MAG Solid wire

**Current:**



**Welding positions:**



**Shielding gas:**  
M12-M13

Hilchrome G308LSi is our solid wire for MAG welding low carbon 18Cr10Ni austenitic stainless steel grades like AISI 304, 304L. Typical applications include all industries where similar materials (incl. higher carbon types) as well as ferritic 13% Cr steels are used. Hilchrome G308L Si is also suitable for Nb (Cb) or Ti stabilised grades 347 and 321. Weld metal has an excellent resistance to general and intergranular corrosion (up to 350°C), good resistance to oxidising acids and cold reducing acids.

## Base materials to be welded:

- ASTM/AISI Grade 302, 304, 304L, 304LN, 321, 347
- WNr 1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4300
- CrNi 18 10 and similar stainless steel grades

## Applications:

- Shipbuilding & Offshore
- Power Generation
- General fabrication & construction works
- Repair & Maintenance
- Process Industry

## Chemical composition, wt.% weld metal – typical:

| C    | Mn   | Si   | Cr   | Ni   |
|------|------|------|------|------|
| 0,02 | 1,70 | 0,90 | 20,0 | 10,0 |

## Mechanical properties, weld metal – typical:

| Condition | 0,2% Yield strength<br>MPa | Tensile strength<br>MPa | Elongation<br>Lo=5d - % | Impact Values<br>ISO-V J |
|-----------|----------------------------|-------------------------|-------------------------|--------------------------|
| As welded | ≥ 320                      | ≥ 550                   | ≥ 35                    | 20°C ≥ 75<br>-196°C ≥ 32 |

Note: properties under M13

## Packaging and welding data:

| Dia.<br>mm. | Spool type | Weight / spool<br>kg. |
|-------------|------------|-----------------------|
| 0,8         | BS300      | 15                    |
| 1,0         | BS300      | 15                    |
| 1,2         | BS300      | 15                    |
| 1,6         | BS300      | 15                    |