



Unibraze 308LSi

CLASSIFICATIONS: AWS A5.9/ASME SFA 5.9 Class ER308LSi UNS S30888

DESCRIPTION:

Unibraze 308LSi is the same as Unibraze 308L with an increased silicon content. This addition assures improved arc stability with excellent washing and wetting behavior resulting in a smooth bead appearance, good penetration, reduced spatter and porosity.

TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu	FN
.03 max	19.5- 22.0	9.0- 11.0	.75 max	1.0- 2.5	.65- 1.0	.03 max	.03 max		.75 max	8

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	86,500 psi (600MPa)
Yield Strength	59,500 psi (410 MPa)
Elongation	39%
Charpy Impacts@-320°F	45 ft lbs

TYPICAL WELDING PARAMETERS:

	Shielding Gas	Gas Flow	Diameter	Voltage	Amperage
MIG	98/99% Ar +2/1% O 97%Ar + 3% CO ₂	30 to 50 CFH	.035" (.9mm)	26-29	160 /210
			.045" (1.14mm)	28-32	180/250
			.062" (1.6mm)	29-33	200/280
TIG	100% Ar		1/16" (1.6mm)	14-18	90/130
			3/32" (2.4mm)	15-20	120/175
			1/8" (3.2mm)	15-20	150/220

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.