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@-320ºF	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) .045" (1.14mm) .062" (1.6mm)	26-29 28-32 29-33	160 /210 180/250 200/280
TIG	100% Ar		1/16" (1.6mm) 3/32" (2.4mm) 1/8" (3.2mm)	14-18 15-20 15-20	90/130 120/175 150/220