**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 PARAMETERS**
Gas: 98% Ar – 2% CO₂ mixture
Packaging: 5 kg and 15 kg spool

<table>
<thead>
<tr>
<th>Diameter</th>
<th>0.8 mm</th>
<th>0.9 mm</th>
<th>1.2 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.30”</td>
<td>100 - 150</td>
<td>120 - 200</td>
<td>140 - 220</td>
</tr>
<tr>
<td>0.35”</td>
<td>120 - 200</td>
<td>140 - 220</td>
<td></td>
</tr>
<tr>
<td>0.45”</td>
<td>140 - 220</td>
<td>160 - 240</td>
<td></td>
</tr>
</tbody>
</table>

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.: 14_03

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

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