**AWS/ASME A5:9 ER308LSi**
**EN ISO 14343-A 19 9 LSi**

TECHNICAL DATA SHEET

## Chemical composition:

| ACX 655 | C | Mn | P | S | Si | Cr | Ni | Mo | N | Cu |
|---|---|---|---|---|---|---|---|---|---|---|
| AWS/ASME | 0.03 | 1.00-2.50 | 0.030 Max. | 0.030 Max. | 0.65-1.00 | 18.00-20.00 | 11.00-14.00 | 2.00-3.00 | - | 0.75 Max. |
| EN-ISO 14343-A | 0.03 | 1.00-2.50 | 0.030 Max. | 0,020 Max | 0.65-1.20 | 18.00-20.00 | 11.00-14.00 | 2.50-3.00 | - | 0.50 Max. |
| ACX 655 | 0.02 | 1.55-1.95 | 0.023 Max. | 0.007 Max | 0.75-0.95 | 18.40-18.80 | 12.10-12.40 | 2.55-2.75 | 0.30-0.50 | 0.15 Max |

## Mechanical properties table: Standard properties IN...

| | 0,2% Yield point (MPa) | Tensile strength (MPa) | Elongation (%) |
|---|---|---|---|
| Welding wire MIG-TIG | ≤1600 | ≤1700 | ≤8 |

## Minimal mechanical properties according to the standard:

| | | Mechanical properties according to EN 14343- A | | |
|---|---|---|---|---|
| EN | Grade (equivalance) | Re 0,2% min. N/mm² (Yield point) | Rm min. N/mm² (Tensile strength) | A% Min. % (Elongation) |
| 19 12 3 L Si | | 320 | 510 | 25 |

## Approvals

VdTÜV, CE, CPR, DB (Approvals for MIG/TIG wire)

## Conditions – Diameter range

**AVAILABLE DIAMETERS mm.**

| WELDING TYPE | 0,80 | 1,00 | 1,20 | 1,60 | 2,00 | 2,40 | 3,20 | 4,00 |
|---|---|---|---|---|---|---|---|---|
| MIG/MAG (GMAW) | | | | | | | | |
| TIG | | | | | | | | |