



GOLDCOR[®] 308LSi

AWS EC308LSi

Replaces: 000630

210-A, INDEX 060203

DESCRIPTION:

GOLDCOR 308LSi is an austenitic stainless steel, gas shielded metal cored wire used wire to join 301, 302, 304, 304L and 308 stainless steels. It produces a concave bead profile and is formulated to run with 98% Argon and 2% Oxygen shielding gas in the spray transfer mode.

GOLDCOR 308LSi was developed to meet the needs of chemical/food service fabricators that have poor to fair fit up and desire a metal cored wire that can produce a moderately soft arc at good welding speeds.

Features	Benefits
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- Little or no slag
- Low spatter
- Soft arc
- Higher travel speeds & higher deposition rates
- Good for vertical down (30-60° incline) welding

- Requires little or no clean-up time
- Promotes good bead appearance
- Excellent welder appeal
- Increases productivity
- Increases throughput time

SHIELDING GAS: 98% ARGON/2% OXYGEN

TYPICAL WELD METAL CHEMISTRY* (CHEM PAD):

Weld Metal Analysis		AWS Spec
Carbon (C)	0.023	0.03 max
Manganese (Mn)	1.50	1.0 to 2.5
Phosphorus (P)	0.020	0.03 max
Sulphur (S)	0.010	0.03 max
Silicon (Si)	0.85	0.65 to 1.00
Copper (Cu)	0.20	0.75 max
Chromium (Cr)	20.50	19.5 to 22.0
Nickel (Ni)	10.1	9.0 to 11.0
Molybdenum (Mo)	0.25	0.75 max

TYPICAL WELD METAL PROPERTIES* (AS WELDED):

		AWS A5.9
DeLong Ferrite Number Range	10-18	not required
Schaeffler Number Range	7-15	not required
WRC Number Range (1992)	8-19	not required

Note: Nitrogen (N) assumed to be 0.06% for calculation purposes.

CONFORMANCES AND APPROVALS:

- AWS A5.9 • ASME SFA5.9 • Class EC308LSi

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RECOMMENDED OPERATING PARAMETERS: For Spray Transfer Welding

Diameter Electric Stickout Position	Arc Voltage (Volts)	Current DCEP (+) (Amps)	Approx. Wire Feed Speed (In/Min)	Deposition Rates (lbs/hr)
.045" (1.2 mm)	22	185	300	8.0
1/2" ± 1/8"	25	275	550	14.0
Flat and Horizontal	29	340	780	20.22
1/16" (1.6 mm)	25	200	153	7.5
1" ± 1/4"	29	300	255	12.1
Flat and Horizontal	34	450	600	27.0

The values above were determined with 98/2 (Ar/O₂), shielding gas. DCEP
BOLD—Optimum parameters for welder appeal.

AVAILABLE DIAMETERS AND PACKAGES:

Diameter Inches	Diameter mm	30-lb. Spool
.045"	1.2	S690812-026
1/16"	1.6	S690819-026

Material Safety Data Sheets on any McKay product may be obtained from McKay Customer Service.

Because McKay is constantly improving products, McKay reserves the right to change design and/or specifications without notice.

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