

GENERAL DESCRIPTION

Elite 833 is an all positional, good general corrosion resistant solid MAG welding wire, depositing a low 23 12 L Si weld metal with a precision layer wound spool winding.

Suitable for welding of austenitic stainless steel such as AISI 309 and a wide range of other welding applications including welding metals with dissimilar composition, an intermediate or buttering layer in the butt welding of clad steel where service temperatures are below 300°C, used as a buffering layer prior to the application hard facing materials. The weld metal has a delta-ferrite content of ~12% resulting in a high resistance to hot cracking.

The silicon content will improve the edge wetting, increased puddle fluidity, smooth bead deposit appearance of the weld metal and is suitable for use with Ar + CO₂ mixed shielding gases.

Typical Applications

- Ideal for welding carbon steels to stainless steels
- For welding 309 and 309L austenitic grades type stainless steel
- Good as a buffer layer in many hardfacing applications

WELDING POSITIONS



CLASSIFICATION

AS/NZS ISO 14343 B-SS309LSi

AWS A5.9 ER309LSi

ISO 14343-A G 23 12 L Si

RECOMMENDED SHIELDING GASES

M13 : 98% Ar + 2% O₂

M12 : Ar + 2 – 5% CO₂.

CHEMICAL COMPOSITION

Wt% -	Si	C	Cu	Mn	Ni	Mo	S	Cr	P
wire	0.65-1.00	0.03max	0.25max	1.50-2.20	12.00-14.00	0.25max	0.03max	23.00-25.00	0.03max

TYPICAL MECHANICAL PROPERTIES

Typical as welded	
Yield Strength	≥ 350
Tensile strength	≥ 550
Elongation A5(%)	≤30%
Impact Energy ASO-V(J) 20°C	≥47

DEPOSITION DATA - DCEP (DC+)

Ar+2~5%CO ₂	1.2mm Diameter
Current (A)	100-210A
Voltage (V)	17-22V
Ar+1~2%O ₂	
Current (A)	200-300A
Voltage (V)	24-30V

Welding parameters are a guide only as they are dependent on the machine used, material thickness and operator experience.

No data is to be construed as a recommendation for any welding condition or technique by Euromarc.

CONFORMANCE AND APPROVAL

CE
LR
TUV

STORAGE

Store all MIG welding wire in their original packaging in a controlled environment of less than 50% relative humidity.

WARNING

Electric shock can kill. Arc rays can injure eyes. Welding fumes are hazardous to your health and may damage lungs and other organs. Use adequate ventilation. Arc rays and sparks can injure eyes and burn skin. Wear correct hand, head, eye and body protection.

Read and understand the Safety Data Sheet for this product.

PACKAGING INFORMATION

Size	Weight	Spool	Part Number / Order code
1.2	12.5kg	D300	VW83301212

