

#### GENERAL DESCRIPTION

Elite 883 is a 23 Cr/ 12 Ni Stainless steel TIG rod. Suitable for welding of stainless steel such as AISI 309 and is used for the welding of dissimilar 300 series austenitic stainless steel and ferritic steels and for buffer layers and buttering layer prior to hardfacing. It is used for depositing intermediate layers on steel prior to depositing 308 grade stainless steel.

Also used for the welding of clad steels where service temperatures are below 300°C. The weld metal has a delta-ferrite content of ~12% resulting in a high resistance to hot cracking.

The increased silicon level results excellent weld pool fluidity to give a smooth deposit bead appearance.

#### Material to be welded:

A 312 TP 309S

Carbon steels to stainless steels joint.

#### WELDING POSITIONS



#### CLASSIFICATION

AS/NZS ISO 14343 B-SS309LSi

AWS / ASME-SFA 5.9: ER 309LSi

EN 12072 : W 23 12 LSi

#### RECOMMENDED SHIELDING GASES

100% Argon

#### CHEMICAL COMPOSITION

Wt% - wire	Si	C	Cu	Mn	Ni	Mo	S	Cr	P
	0.60-1.00	0.03max	0.25max	1.50-2.20	12.00-14.00	0.25 max	0.03max	23.00-25.00	0.03max

#### TYPICAL MECHANICAL PROPERTIES

##### Typical as welded

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

#### WELDING CURRENT

DCEN (-)

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 TIG filler rods 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	Length	Part Number / Order code
1.6mm	5kg	1000mm	VR88316105
2.4mm	5kg	1000mm	VR88324105

All rods are embossed for ease of identification.

