

GENERAL DESCRIPTION

Elite 881 is a 20 Cr / 10 Ni stainless steel TIG welding wire similar in composition to ER 308LSi, suitable for welding of austenitic stainless steels such as 18 Cr/ 8 Ni type, AISI 304, 304L and 308LSi type of steels. Excellent corrosion resistance and good mechanical properties. Ferrite is controlled between 5% to 10 %. Silicon – 0.85 % approx content improves weldability and bead appearance.

Extra low carbon increases inter-granular corrosion resistance. Excellent crack resistance.

Material to be welded:

Steel Grades	EN 10088-1/-2	EN 102 13-4	W.Nr.	ASTM /ACI A240/A312 /A351	UNS
Extra low carbon (C <0.03%)	X2CrNi19 11		1.4306	(TP)304 L CF-3	S30403 J92500
	X2CrNi18 10		1.4311	(TP)304LN 302, 304	S30453 S30400
Medium carbon (C >0.03%)	X4CrNi18 10	GX5CrNi19 10	1.4301 1.4308	(TP)304 CF-8	S30409 J92600
	X6CrNiTi18 10		1.4541	(TP)321 (TP)321H	S32100 S32109
Ti-, Nb stabilized	X6 CrNiNb 18 10	GX5 CrNiNb 19 10	1.4550 1.4552	(TP)347 CF-8C	S34700 J92710

WELDING POSITIONS



CLASSIFICATION

AS/NZS ISO 14343 B-SS308LSi
EN 12072 : W 19 9 LSi
AWS A 5.9 : ER 308 LSi

RECOMMENDED SHIELDING GASES

100% Argon

CHEMICAL COMPOSITION

Wt% - wire	Si	C	Cu	Mn	Ni	Mo	S	Cr	P
	0.65-1.00	0.03max	0.75max	1.50-2.20	9.00-11.00	0.75 max	0.03max	19.50-22.00	0.03max

TYPICAL MECHANICAL PROPERTIES

Typical as welded

Yield Strength	≤350MPa
Tensile strength	≤520 MPa
Elongation	≤35%
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
DB

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
1.2mm	5kg	1000mm	VR88112105
1.6mm	5kg	1000mm	VR88116105
2.0mm	5kg	1000mm	VR88120105

All rods are embossed for ease of identification.

