AS MIG 309LSi

MIG Wire for Welding of Austenitic Stainless Steels

Classification

AWS A5.9 : ER309LSi
ISO 14343-A : G 23 12 LSi

General Description

Solid wire for welding stainless steel to carbon steel.

With increased silicon for improved wettability.

Chemical Composition (w%), Typical, Wire

C	Si	Mn	Cr	Ni	Mo	P+S
< 0.03	0.85	1.70	24	13	0.15	< 0.035

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 420 N/mm²
Tensile Strength : 600 N/mm²
Elongation (L=5d) : 35 %
Impact ISO-V : 120 J (+20°C)

Approvals

GOST

Shielding Gases (acc. ISO 14175 and EN 439)

MIG : M13 - Ar + % 1.5 - 3 O_2
M12 - Ar + % 1 - 5 CO_2

Materials to be Welded

	EN 10088-1/-2	Mat. Nr.
Corrosion resistant cladsteels	X2 CrNiN 18 10	1.4311
	X2 CrNi 19 11	1.4306
	X4 CrNi 18 10	1.4301

Dissimilar metals (mild and low alloyed steel to stainless steel)

Build-up welding on mild and low alloyed steel

Packaging and Available Sizes

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Spool Weight
MIG Wire	X	X	X	-	-	-	-	12.5 kg