

## 309LSi

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Solid stainless steel welding wire for dissimilar welding

**APPLICATIONS** Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.

**PROPERTIES** High mechanical properties and very good weldability due to a ingreased silicon content, suitable for operating temperatures up to 300°C.

**CLASSIFICATION**

AWS	A 5.9: ER 309 LSi
EN ISO	14343-A: W 23 12 L Si
	14343-B: SS309LSi
DIN: W.Nr.	1.4332
DIN	8556: SG X2CrNi 24 12

**SUITABLE FOR** Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels such as: 42CrMo4, C45, 42MnV7, tool steels etc.

**APPROVALS** TUV (12395.00), CE approved

**WELDING POSITIONS:**



### WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo
<0.03	2.00	0.90	24	13	-

### REINES SCHWEISSGUT ERGEBNISSE

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				+20°C	-40°C	-110°C	
AW	440	600	37	160		90	

AW: as welded

### WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool	kg / pallet
0,8	15-24	55-160	D-200 / K-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000
1,0	15-28	80-240	D-200 / K-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000
1,2	15-29	100-300	D-200 / K-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** M11, M12, M13