

M-309LSi

AWS ER309LSi
JIS Y309LSi

FOR STAINLESS STEEL

Typical applications

Welding of austenitic stainless alloys of the 22%Cr-12%Ni low carbon types and for joining stainless steels to non-alloy or low-alloy steels.

The high silicon content improves the welding properties, such as wetting.

Typical chemical composition of wire (%)

| C | Si | Mn | Ni | Cr |
|------|------|------|-------|-------|
| 0.02 | 0.75 | 2.28 | 13.70 | 23.20 |

Typical mechanical properties of all-weld-metal

| Shielding Gas | T · S N/mm ² {kgf/mm ² } | El (%) | IV (J) |
|---------------------|---|-----------|-----------|
| Ar+2%O ₂ | 590 {58} | 40 | 0.°C: 90 |

Package

| | | | | | | |
|---------------|-------------|-----|-----|---------------|-----|-----|
| Dia. (mm) | 0.8 | 0.9 | 1.0 | 1.2 | 1.4 | 1.6 |
| Spool. (kg) | 5, 12.5, 20 | | | | | |
| Pailpack.(kg) | 200, 250 | | | 200, 250, 300 | | |

Approved by