


309LSi Tig

CATEGORY	GMAW-GTAW Solid wires																												
TYPE	Stainless steel Tig 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, CE approved																												
WELDING POSITIONS:																													
WELD METAL ANALYSIS	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td><0.03</td> <td>2.00</td> <td>0.90</td> <td>24</td> <td>13</td> <td>-</td> </tr> </tbody> </table>					C	Mn	Si	Cr	Ni	Mo	<0.03	2.00	0.90	24	13	-												
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GAS ACC. EN ISO 14175:	I1																												