



**GMAW / GTAW STAINLESS STEEL**  
**MIGINOX 309LSi**

309LSi TYPE STAINLESS STEEL SOLID WIRE



**CLASSIFICATION :** EN ISO 14343-A    AWS A/SFA 5.9    **APPROVALS :**

G 23 12 LSi

ER309LSi

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**KEY FEATURES :**

- An extra low carbon 24Cr/13Ni type stainless steel solid wire
- High Si content improves wetting characteristics
- Excellent corrosion and oxidation resistance up to 1100°C
- Highest cracking resistance
- Radiographic quality welds

**WELDING POSITION :**



**DCEP**

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
98Ar/2O <sub>2</sub> or Ar/1-5CO <sub>2</sub>	15-22	10-20

**TYPICAL APPLICATIONS :**

- Welding of AISI 309, 309L type steels
- Dissimilar joints between stainless steels and low alloy or carbon steels
- Buffer layer on low alloy and carbon steels
- Joining corrosion resistant clad steels

**STORAGE / HANDLING :**

Keep dry and follow handling instructions mentioned on the box

**CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :**

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.03 max	1.0-2.5	0.65-1.0	23.0-25.0	12.0-14.0	0.75 max	0.03 max	0.03 max

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

	Condition	UTS, MPa	EL%
Specification	As Welded	520 min	30 min

Mechanical properties will vary with the type of shielding gas used.

**PACKING DATA :**

Ø, mm	Kg/Spool
0.8	12.5
1.2	12.5
1.6	12.5
2.0	12.5