MIG / TIG 309LSi

MIG/TIG 309LSi is mainly used under high dilution conditions, particularly Dissimilar welds between stainless and CMn steels. There are 3 main areas of application: Buffer layers and clad steels, Dissimilar joints and Similar metal joints.

MATERIALS TO BE WELDED

There are 3 main areas of application. Buffer layers and clad steels. Dissimilar joints and Hardenable steels

CLASSIFICATIONS

AWS	A5.9	ER309LSi
BS EN	12072	G 23 12 L Si
DIN	8556	SG X2CrNi 24 12 (1.4332)

CHEMICAL ANALYSIS

% Carbon	0.015	**% Chromium**	23.50
% Manganese	1.700	**% Nickel**	13.00
% Silicon	0.800	**% Molybdenum**	0.100
% Sulphur	0.005	**% Copper**	0.150
% Phosphorus	0.015	**% Ferrite**	12.00

TYPICAL MECHANICAL PROPERTIES ALL WELD METAL

	MIG	TIG		MIG	TIG
Tensile Strength	560 MPa	605 MPa	**Impact Energy 20°C**	100J	100J
0.2% Proof Stress	430 MPa	400 MPa	**Impact Energy -20°C**	80J	80J
Elongation on 4d	42%	44%			

Microstructure
Austenite with ferrite in the range 8-20FN.

PACKING DATA

MIG (DC+)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
0.80	120	19	033-035	15
0.90	160	23	033-036	15
1.00	200	26	033-222	15
1.20	260	26	033-228	15
1.60	280	28	033-039	15

TIG (DC-)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.60	100	12	030-425	5
2.00	100	12	030-426	5
2.40	100	12	030-427	5

Suggested gas for welding : Stainshield Plus, Stainshield (MIG), Argon (TIG)

For more information contact the Afrox Customer Service Centre,
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