



309LSi XM

AWS A 5.9: ER309LSi ISO 14343-A: G 23 12L Si

DESCRIPTION

Mig wire for welding stainless steels of similar composition or ferritic stainless steels. Joining stainless steels to mild and low-alloyed steels. Rebuilding and buffering before cladding or hardfacing. Maintenance on « hard-to-weld steels ». Examples: Dissimilar welds between stainless steels type 304, 304L, 316, 316L, 318, 316Ti, 321, 410 or ferritic stainless steels type 1.4713, 1.4724, 1.4742, 3Cr12, to non or low alloyed CMn steels, for service temperatures up to 400°C.

WELDING POSITIONS



POLARITY

DC+

GAS

M12 (Ar/ Co₂)

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
600	440	41	+20°C – 160j -60°C – 130j

CHEMICAL ANALYSIS(%)

C	Mn	Si	Ni	Cr
0,03	1,5	0,85	12,5	23,5

PACKING INFORMATION AND WELDING PARAMETERS

Dimension(mm)	0,8	1,0	1,2	
Spool(kg)	1/5/15	1/5/15	5/15	
Wire feeding/min	3,4-11	2,9-8,4	4,9-8,5	
Current(A)	50-140	80-190	180-280	
Volt(V)	16-22	16-24	20-28	

EQUIVALENT CONSUMABLES

MMA	Meltolit 309L E
TIG	Meltolit 309LSi XT
FCW	Meltolit 309 FCW/FCW-PW