



309LSi XT

AWS A 5.9: ER309LSi ISO 14343-A: W 23 12 LSi

DESCRIPTION

Tig 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

Ar (11)

MECHANICAL PROPERTIES

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

CHEMICAL ANALYSIS(%)

| C | Mn | Si | Ni | Cr | |
|-------|-----|-----|------|------|--|
| 0,015 | 1,7 | 0,8 | 13,0 | 23,5 | |

PACKING INFORMATION AND WELDING PARAMETERS

| Dimension(mm) | 1,2 | 1,6 | 2,0 | 2,4 | 3,2 |
|---------------|-------|-------|--------|---------|---------|
| Box(kg) | 5 | 5 | 5 | 5 | 5 |
| Amperage(A) | 40-70 | 50-80 | 70-110 | 110-180 | 150-250 |

EQUIVALENT CONSUMABLES

| | |
|-----|--------------------------|
| MMA | Meltolit 309L E |
| MIG | Meltolit 309LSi XM |
| FCW | Meltolit 309L FCW/FCW-PW |