ELBOR
STAINLESS STEEL MIG WIRE AWS A 5.9 309 L/ LSI

The 309LSi deposits a 24% Cr / 13% Ni austenitic stainless steel weld metal with a nominal ferrite content of FN 10. The relatively high alloy and ferrite levels enable the weld metal to tolerate dilution from mild or low alloyed steels without hot cracking. The higher silicon content provides a more fluid weld pool which may be preferred for certain welding applications such as :
- Buffer layers on mild and low alloy steels prior to overlaying with MIG/TIG 308L.
- Joining of clad steels and dissimilar joints between stainless and mild or low alloy steels.
- Welding of similar composition, 309L type, stainless steels.
- Joining of ferritic - martensitic stainless steels.

NORM: EN ISO 14343-A-G23 12 L Si - WERKSTOFF. 1.4332

MATERIAL TO BE WELD :

304/304L/304LN/ 309/309L/309S/CF3/TP 309 / TP 309S

TYPICAL CHEMICAL CONTENT :

Mo	**0.10-0.15**
Cr	**23.00-25.00**
Ni	**13.00-15.00**
Mn	**1.50-3.00**
Si	**0.60-0.80 (0.30-0.50 -309L)**
Cu	**0.10**
C	**0.02**

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

Elongation	**35 %**
Impact Strenght Kv (+20°C)	**>47 J**
Tensile Strenght	**650 MPa**
Yeld Strenght	**450 MPa**

Welding positions :

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