LNM 309LSi

CLASSIFICATION

AWS A5.9	ER309LSi	**A-Nr**	8	**Mat-Nr**	1.4332
ISO 14343-A	G 23 12 LSi	**F-Nr**	6		
		9606 FM	5		

GENERAL DESCRIPTION

Solid wire for welding stainless steel to carbon steel
With high silicon for improved wettability

WELDING POSITIONS (ISO/ASME)

PA/1G PB/2F PC/2G PD/4F PE/4G PF/3Gu

SHIELDING GASES (ACC. ISO 14175)

M12	Mixed gas Ar+ 0.5-5% CO_2
M13	Mixed gas Ar+ 0.5-3% O_2

APPROVALS

ABS	BV	DB	DNV	GL	LR	TÜV
+	+	+	+	+	+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo
0.02	1.8	0.8	23.3	13.8	0.14

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) -20°C	Impact ISO-V(J) +20°C
Typical values	M12	AW	436	582	37	80	87

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	Mat. Nr	ASTM	UNS
Corrosion resistant cladsteels				
	X2CrNiN18-10	1.4311	(TP)304LN	S30453
	X2CrNi19-11	1.4306	(TP)304L	S30403
			CF-3	J92500
	X4CrNi18-10	1.4301	(TP)304	S30400

Dissimilar metals (mild and low alloy steel to stainless steel)
Build-up welding on mild and low alloy steel

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2	1.6
15 kg spool BS300	X	X	X	X
250 kg Accutrak® Drum		X	X	

Other sizes and packaging on request

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