



PRODUCT DATA SHEET

STAINLESS STEEL TIG WIRE

309LSI TIG



SUMMARY

- > A stainless steel TIG wire
- > For joining dissimilar steels
- > Shielding gas – Argon
- > Polarity – Dc -

CLASSIFICATION

- > AS/NZS ISO 14343-B-SS309LSI
- > AWS A5.9: ER309LSI

DESCRIPTION AND APPLICATION

Low carbon 24Cr/13Ni type filler rod recommended for TIG and oxy-acetylene welding of 309 and 309L stainless steels. Also suitable for joining dissimilar steels such as stainless steel to mild or low alloy steels and for stainless surfacing of mild steel, carbon and low alloy steels. This TIG wire has low carbon and higher silicon content which improves the fluidity of the filler metal during welding.

Suitable for welding dissimilar metals & buffer layers.

TYPICAL ROD ANALYSIS

Ci	Mn	Si	Cr	Ni	Mo
0.03	1.90	0.92	23.20	13.6	0.10

TYPICAL DEPOSIT ANALYSIS

Tensile Strength	630 MPa
Elongation	31%

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.6	1kg packet	TIGSS309LSI16V
2.4	1kg packet	TIGSS309LSI24V

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