



# PRODUCT DATA SHEET

## STAINLESS STEEL WIRE

### 309LSi



#### SUMMARY

- > Shielding Gas - Argon/CO<sub>2</sub>\* or Argon/ Oxygen 2%
- > Polarity - DC +

#### CLASSIFICATION

- > AS/NZS ISO 14343-BSS309LSi
- > AWS A5.9: ER309LSi

#### DESCRIPTION AND APPLICATION

Precision layer wound stainless steel welding wire depositing 25Cr/13Ni type low carbon weld metal. Recommended for welding 309, 309Mo and 309L base materials, also stainless steel to mild and low alloy steels, stainless steel overlays and other dissimilar ferrous metals.

Suited to welding dissimilar metals & buffer layers.

#### OPERATIONAL DATA

Welding parameters shown below are for DC Electrode negative only.

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLT. RANGE *(V)
0.9	80 - 220	15 - 24

Welding Current DC -

\*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

#### TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo
0.03	1.90	0.92	23.30	13.6	0.10

#### TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Tensile Strength	630 MPa
Elongation	31%

#### PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
0.9	15kg spool	MIGSS309LSI09
1.2	15kg spool	MIGSS309LSI12

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