

LNT 309LSi

CLASSIFICATION

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

GENERAL DESCRIPTION

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

SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

APPROVALS

TÜV	CE
+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo
0.02	2.0	0.8	23.5	13	0.1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -120°C
Typical values	I1	AW	400	600	35	65

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	Mat. Nr	ASTM/ACI	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)	1.6	2.0	2.4	3.2
5 kg PE-Tube	X	X	X	X

Note : Cut length = 1000 mm

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