WI **SG 309 L Si**

Stainless Steel Gas Shielded Welding Wire

CLASSIFICATIONS

EN ISO 14343-A : G 23 12 L Si
AWS A5.9 : ER 309 L Si

DESCRIPTION

- Applicability on ferritic Cr or austenitic CrNi steels, austenitic manganese steels, unalloyed high-strength steels, heat-treated steels
- Usability in welding austenitic stainless steels, in joint- welding of different kinds of metals, in buffer layers, in joint-welding of corrosion-resistant stainless steels to each other or to low-alloyed steels, and in welding coated steels
- Ar+ %2.5 O_2 or (Ar+%2.5 CO_2) gas is used as shielding gas

CHEMICAL ANALYSIS OF WELD METAL % *(TYPICAL)*

C: 0.03 | Si: 0.80 | Mn: 1.80 | Cr: 23.5 | Ni: 13.0

MECHANICAL PROPERTIES

Yield Strength (MPa)	**Tensile Strength** (MPa)	**Impact Strength** (ISO-V/+20°C)	**Elongation** (L_o=5d_o) (%)
min. 320	min. 520	min. 47 J	min. 30

BASE MATERIALS

- Ferritic Cr and austenitic CrNi steels, austenitic manganese steels, unalloyed high strength steels, high temperature steels.

WELDING POSITIONS

CURRENT CONDITION

MIG D.C.(+)

OPERATING DATA

Product Code	**Diameter x Length** (mm) / (inch)		**Weight** (Kg)	**Package Type**
1011100033	0.8	0.030"	12.5	BS 300
1011100034	1.0	0.040"	15	BS 300
1011100035	1.2	0.047"	15	BS 300