

M-309LSi

AWS ER309LSi
JIS Y309LSi

FOR STAINLESS STEEL

Typical applications

Welding of austenitic stainless alloys of the 22%Cr-12%Ni low carbon types and for joining stainless steels to non-alloy or low-alloy steels.

The high silicon content improves the welding properties, such as wetting.

Typical chemical composition of wire (%)

C	Si	Mn	Ni	Cr
0.02	0.75	2.28	13.70	23.20

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	El (%)	IV (J)
Ar+2%O ₂	590 {58}	40	0.°C: 90

Package

Dia. (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool. (kg)	5, 12.5, 20					
Pailpack.(kg)	200, 250			200, 250, 300		

Approved by