

ES MIG 309LSi

GMAW
ER309LSi

ESWECO
The Art of Welding

Description

ES MIG 309LSi is a continuous, solid, corrosion-resistant, chromium-nickel wire for welding steels with a similar composition, wrought and cast steels of the 23% Cr-12% Ni types. The alloy is also used for welding buffer layers on C/Mn steels and welding dissimilar joints. When using the wire for buffer layers and dissimilar joints, it is necessary to control the dilution of the weld.

ES MIG 309LSi has good general corrosion resistance. The higher silicon content improves the welding properties such as wetting.

Current

DC+

Classifications

SFA/AWS A5.9	ER309LSi
EN 12072	G 23 12 LSi
Werkstoffnummer	~1.4332

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.8	1.8	24.0	13.0	<0.3	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	440
Tensile strength, MPa	600
Elongation, %	41

Charpy V

Test temps, °C	Impact values, J
+20	160
-60	130
-110	90

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V
0.8	4.0-17.0	55-160	15-24
1.0	4.0-16.0	80-240	15-28
1.2	3.0-14.0	100-300	15-29
1.6	5.5-9.0	230-375	23-31