

LNM 309LSi

CLASSIFICATION

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

GENERAL DESCRIPTION

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

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

SHIELDING GASES (ACC. ISO 14175)

| | |
|-----|--------------------------------------|
| M12 | Mixed gas Ar+ 0.5-5% CO ₂ |
| M13 | Mixed gas Ar+ 0.5-3% O ₂ |

APPROVALS

| | | | | | | |
|-----|----|----|-----|----|----|-----|
| ABS | BV | DB | DNV | GL | LR | TÜV |
| + | + | + | + | + | + | + |

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

| | | | | | |
|------|-----|-----|------|------|------|
| C | Mn | Si | Cr | Ni | Mo |
| 0.02 | 1.8 | 0.8 | 23.3 | 13.8 | 0.14 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| | Shielding gas | Condition | 0.2% proof strength | Tensile strength | Elongation | Impact ISO-V(J) | |
|----------------|---------------|-----------|----------------------|----------------------|------------|-----------------|-------|
| | | | [N/mm ²] | [N/mm ²] | [%] | -20°C | +20°C |
| Typical values | M12 | AW | 436 | 582 | 37 | 80 | 87 |

EXAMPLES OF MATERIALS TO BE WELDED

| Steel grades | EN 10088-1/-2 | Mat. Nr | ASTM | 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] | 0.8 | 1.0 | 1.2 | 1.6 |
|-----------------------|-----|-----|-----|-----|
| 15 kg spool BS300 | X | X | X | X |
| 250 kg Accutrak® Drum | | X | X | |

Other sizes and packaging on request

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