



MIG 309LSi



Standards

AWS 5.9
ER 309LSi

EN ISO 14343-A
G 23 12 L Si

W. Nr.
1.4332

Description & applications

Filler metal in solid wire spools for MIG welding of stainless steels with mild or low alloy steels, as well as barrier layer for overlays of stainless steels on such substrates. Good overall resistance to corrosion & high temperature oxidation. The high Silicon content improves the wettability/fluidity of the molten metal.

Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Mo	S max	P Max	Fe
0.025	1.8	0.9	24.0	13.0	0.3	0.02	0.02	Base

Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV-196°C
620 MPa	420 MPa	36 %	46 J

Operating parameters

Shielding gas recommendations :

EN ISO 14175 M12 : Argon + 2-3 % CO₂ or Argon + 1-2 % O₂ / 12 -18 l/mn



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