

Key Facts

- Precision Layer wound wire
- Used to weld 23%Cr, 12%Ni stainless steel
- Easy starting and Smooth feeding wire
- Higher Silicon content improves weld edge wetting

Description

Premium quality, low carbon stainless steel wire for welding matching 309L type stainless steel. The low carbon content improves corrosion resistance and the extra silicon aids weld pool fluidity. Shielding Gas; Ar or Ar/CO₂ mix. Welding positions; flat, horizontal, vertical-up, vertical-down and overhead.

Classification, Approvals & Conformances

A5.9 ER309LSi
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 DIN8556 SG X2 CrNi 24 12

Recommended Shielding Gas

98/99% Argon + 2/1% Oxygen
 97% Argon + 3% CO₂

Welding Positions

All positions

Applications

Used to weld 23% Cr/12% Ni stainless. Also recommended for welding stainless steel to mild and low alloy steels, stainless steel overlays and other dissimilar ferrous metals. Can be used as a buttering layer on carbon for hard-facing consumables.

- Welding Dissimilar materials
- Buffer layers prior to Hard Facing and Overlays
- Joining of wrought or cast steels

Typical Wire Analysis

| C - Carbon | Mn - Manganese | Si - Silicon | Cr - Chromium |
|-------------|-----------------|----------------|---------------|
| < 0.03 | 1.0 – 2.5 | < 0.65 – 1.0 | 23.0 – 25.0 |
| Ni - Nickel | Mo - Molybdenum | P - Phosphorus | S - Sulphur |
| 12.0 – 14.0 | < 0.75 | < 0.03 | < 0.03 |
| Cu - Copper | Fe - Iron | | |
| < 0.75 | Remainder | | |

Typical All Weld Metal Mechanical Properties

| | |
|---------------------------------|------------------------|
| 0.2% Proof Stress | > 385N/mm ² |
| Tensile Strength: | 595N/mm ² |
| Elongation (5xD): | 37% |
| Impact Strength Charpy-V | 100J @ +20°C |

Packaging & Ordering Information

| Size | Packet | Part Number |
|-------|--------|-------------|
| 0.9mm | 15kg | 200045 |
| 1.2mm | 15kg | 200046 |

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.