MIGWELD 309LSi

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : G 23 12 LSi DIN 8556 : SG-X2 CrNi24 12 AWS A-5.9 : ER 309 LSi W.Nr. : 1.4332	TUV	Power generation industry Constructions & Engineering Mining Petrochemical and chemical industry Shipbuilding&Offshore

- High-alloy wire used for welding homogeneous as well as forged or cast steels.
- Also used for welding 18-8 steels subject to severe corrosion.
- Particularly recommended for welding dissimilar steels such as 18-8 to mild steel and for overlaying stainless steel on mild, carbon, and low-alloy steel.

Application

Furnaces (burners, doors, fans, piping, recuperators, grates, air boxes), paper mill equipment, petroleum refining (catalytic recovery systems, recuperators), power generation (powder burners, pipe hangers), thermal treatment, waste incineration plants, rotary kilns, calciners, automotive exhaust system components, heat exchangers, glass blowing components, aircraft parts, boiler partitions, furnace linings, porcelain firing baskets, annealing containers, inserts for chimneys operating in dry conditions.

Base material

PN	EN 10088-1/2	W.Nr.	AISI/ASTM
	X10 CrSi6	1.4712	
H6S2	X10CrAl7	1.4713	
	X10 CrSi13	1.4722	
H13JS	X10CrAl13	1.4724	405
	X10 CrSi18	1.4741	
H18JS	X10 CrAl18	1.4742	442
H24JS	X10 CrAl24	1.4762	446
	X10CrSi29	1.4772	
	X20CrNiSi25 4	1.4821	
	G-X25 CrNiSi18 9	1.4825	
	G-X40 CrNiSi22 9	1.4826	
H20N12S2	X15 CrNiSi20	1.4828	309
	G-X25 CrNiSi20 14	1.4832	
OH18N9	X5 CrNi18 10	1.4301	304H
OOH18N10	X2 CrNi18 11	1.4306	304L
	G-X10 CrNi18 8	1.4312	305
	X2 CrNiN18 10	1.4311	304LN
	X10 CrNiTi18 9	1.4541	321
	X6 CrNiNb18 10	1.4550	347

Typical chemical composition %

C	Si	Mn	Cr	Ni
<0,025	0,80	1,60	23,50	13,50

Typical mechanical properties

Yield strength Re [N/mm2]	>380
Tensile strength Rm [N/mm2]	550-700
Elongation A5 [%]	>22
Impact energy Kv [J]	>32 J (-196°C) /
Wire/rod type	solid
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	I1 - Ar / M12 - Ar + 0.5 - 5% CO2 / M13 - Ar + 0.5 - 3% O2 /

Welding parameters and packing

⌀	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	100-160	18-22	15,0
1,0	140-200	18-24	15,0
1,2	170-260	20-28	15,0
1,6	220-350	24-36	15,0

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