

TI 309LSi

TIG Welding Wire - Stainless Steels

Standards

AWS/ASME SFA - 5.9	ER309LSi
EN ISO 14343 - A	W 23 12 LSi
TS EN ISO 14343 - A	W 23 12 LSi

Properties and Applications

Austenitic-ferritic wire electrode for GTA (TIG)-welding of stainless steels to unalloyed or low-alloyed steels, subject to operating temperatures up to 300°C. Low carbon content increases resistance to intergranular corrosion. Suitable to use also as buffer layer on carbon steel before welding with 308 and 308 L to reach 304 and 304L surface layer. The higher silicon content improves the welding properties, such as wetting and smoother weld bead appearance.

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni
Welding Wire	0.02	0.80	1.75	23.50	13.50

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	I1	440	575	35	-30°C → 90	-196°C → 62

* Chemical composition and mechanical properties are valid when using shielding gas .

Application Information

Welding Positions

PA PB PC PD PE PF

Polarity:

Protection Gas:
I1

Welding Parameters & Efficiency

Diameter x Length (mm)
2.40x1000

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
23103IBKM5	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube