

INERTFIL 309LSI

Gazaltı (MIG/MAG) Kaynak Teli - Stainless Steels

Standards	
AWS/ASME SFA - 5.9	ER309LSI
EN ISO 14343 - A	G 23 12 LSi
TS EN ISO 14343 - A	G 23 12 LSi
DIN M. No.	1.4332

Properties and Applications

Austenitic-ferritic wire electrode for GMA (MIG/MAG) welding of dissimilar joints of stainless steels to unalloyed or low-alloyed steels, subjected to operating temperatures up to 300°C. Suitable to use also as buffer layer on carbon steel before welding with 308 and 308L to reach 304 and 304L layer. Low carbon content increases resistance to intergranular corrosion.

Materials		
Width	Material	ASTM
X5CrNi18-10	1.4301	304
X2CrNi19-11	1.4306	304L
X6CrNiTi18-10	1.4541	321
X5CrNiMo17-12-2	1.4401	316
X2CrNiMo18-14-3	1.4435	316L
X6CrNiMoTi17-12-2	1.4571	316 Ti
	1.4583	318

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni
Welding Wire	0.01	0.70	1.90	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	M13	460	600	38	20°C → 100

* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M13 (Ar+%0,5-3 O2) .

Application Information

Welding Positions

PA PB PC PD PE PF PG

Polarity:

Protection Gas:
M13 M12 M14 I1

Welding Parameters & Efficiency

Diameter (mm)
0.80
1.00
1.20
1.60

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
23003BAKM2	0.80	1 kg	1.10	14	15.70	Plastic Spool (D100)
23003BBAM2	0.80	5 kg	5.30	1	5.30	Plastic Spool (D200)
23003BJAM2	0.80	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23003DBAM2	1.00	5 kg	5.30	1	5.30	Plastic Spool (D200)
23003DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23003EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23003GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.