Weldability® Sif

## PRODUCT INFORMATION

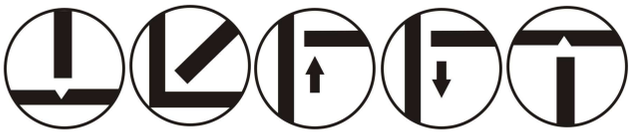
# SIFMIG 309LSI

EN ISO 14343: 23 12 LSi,
AWS A5.9: ER 309LSi
BS: 2901 309 S93

## DESCRIPTION

This stainless steel wire contains higher chromium and Nickel. It can be used for joining material of similar composition and also dissimilar stainless steels.

## WELDING POSITIONS



SIFSTEEL 309LSi is our solid wire for MAG welding corrosion resistant and heat resistant CrNi steels, dissimilar metals and buffering.

## TYPICAL WELD METAL COMPOSITION

| | |
|---|---|
| C | 0.1 % |
| Si | 0.4 % |
| Mn | 1.5 % |
| Ni | 13 % |
| Cr | 26 % |

## TYPICAL MECHANICAL PROPERTIES

| | |
|---|---|
| Melting Point | 1440℃ |
| Ult Tensile Strength | 650 N/mm² |
| Hardness | 180 |

## MATERIAL TO BE WELDED

Typical applications include joining high-strength steels, un- and low alloyed heat treatable steels, stainless, ferritic chromium and austenitic chrome-nickel steels, austenitic manganese steels. SIFSTEEL 309LSi is suitable for joining clad steels. The FN content (FN~16) ensures good cracking resistance.
Base materials to be welded: High strength, unalloyed and alloyed heat treatable steels; stainless, ferritic chromium and austenitic CrNi steels; austenitic manganese steels. Chemically resistant weld claddings ranging from ferritic-pearlitic steels to fine grain steels, incl. high temperature fine grain steels. Dissimilar joining.

## AVAILABLE FORMATS

| SPOOLED WIRE (MIG / GMAW) | | | |
|---|---|---|---|
| Dia | | 3.75kg | 15kg |
| 0.8mm | | WO340840 | WO340815 |
| 1.0mm | | WO341040 | WO341015 |
| 1.2mm | | WO341240 | WO341215 |

| | |
|---|---|
| Current : | DC = + |
| Shielding Gas : | M13, ArCO2 |

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email **service@wholeweld.co.uk**

nqa. ISO 9001 Registered 015 UKAS QUALITY MANAGEMENT

Registered in England No. 1684362
Registered Office: as above

Doc Ref : SIF/PI/WO340840