Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 309LSi

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REASON FOR ISSUE

Mechanical values are updated

GENERAL

Bare corrosion resistant chromium-nickel welding rod for welding of similar steels, wrought and cast steels of 23% Cr-12% Ni types. The alloy is also used for welding of buffer layers on CMn steels and welding of dissimilar joints. When using the wire for buffer layers and dissimilar joints it is necessary to control the dilution of the weld.

OK Tigrod 309LSi has a good general corrosion resistance. The higher silicon content improves the welding properties, such as wetting.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Austenitic (with approx. 8 % ferrite) 24 % Cr - 13 % Ni - Low C

CLASSIFICATIONS Wire Electrode

EN ISO 14343-A	W 23 12 L Si
SFA/AWS A5.9	ER309LSi
Werkstoffnummer	~1.4332

APPROVALS

CE	EN 13479
VdTÜV	06278 (FP)

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	**Min**	**Max**
C	0.02		0.03
Si	0.8	0.65	1.00
Mn	1.7	1.4	2.2
P	0.02		0.030
S	0.01		0.020
Cr	24	23.0	25.0
Ni	13	12.0	14.0
Mo	0.1		0.3
Cu	0.1		0.3
N			0.11
Others tot			0.50

MECHANICAL PROPERTIES OF WELD METAL

	All Weld Metal	
	As welded	
Properties	**Min**	**Typ**
Rp0.2 (MPa)	420	475
Rm (MPa)	530	635
A4-A5 (%)	25	32
at 20°C (J)		150
at 0°C (J)	47	150
at -60°C (J)		150
at -110°C (J)		130