CROMATIG 309LSi

Solid wire Gas
Tungsten Arc Solid

Classifications EN ISO 14343-A W 23 12 L Si
AWS A5.9 ER309LSi

CROMATIG 309LSi deposits a 24% Cr / 13% Ni austenitic stainless steel weld metal with a nominal ferrite content of FN 10. The relatively high alloy and ferrite levels enable the weld metal to tolerate dilution from mild or low alloyed steels without hot cracking. The higher silicon content provides a more fluid weld pool which may be preferred for certain welding applications.
Applications : - Buffer layers on mild and low alloy steels prior to overlaying with MIG/TIG 308L. - Joining of clad steels and dissimilar joints between stainless and mild or low alloy steels. - Welding of similar composition, 309L type, stainless steels. - Joining of ferritic-martensitic stainless steels.

Shielding Gas I1, Ar 99.99%, 6-12 l/min / ,

Welding Current DC-

Scaling temperature

Corrosion resistance

Weld metal chemistry %

FN 11

	%C	%Si	%Mn	%P	%S	%Cr	%Ni	%Mo	%Cu
Min		0,65	1,0			22,0	11,0		
Typical	0,02	0,8	1,8	0,015	0,01	23,5	13,5	0,10	0,10
Max	0,030	1,00	2,5	0,03	0,020	25,0	14,0	0,30	0,30

Notes :
Stamping:
Elga, AWS, Wst, EN, Batch

Mechanical properties Welding Conditions : As Welded

Typical values		
Yield Strength, Re	450	MPa
Tensile Strength, Rm	650	MPa
Elongation A5	35	%

	T °C	Typical (J)
Impact energy, CV	+20	130
	-120	65

Minimum values		
Yield Strength, Re	350	MPa
Tensile Strength, Rm	520	MPa
Elongation A5	30	%

CE	TÜV	DB	LR	DNV	BV	ABS	RINA	RMS	NAKS
X	X								

Available diameters : 1.6 - 2.4mm