



AWS A5.9: ER309Lsi  
ISO 14343-A-2009-23 12 Lsi

# Stainless Steel Solid Wire

## MIG/TIG Welding

### SW-309LSi

#### DESCRIPTION & APPLICATION

MIG/TIG Filler wire for the joining and overlay of Stainless Steels of similar composition, such as AISI 309 castings. Low carbon content minimises Carbide precipitation. May also be used as a dissimilar consumable and for joining 3Cr12. Increased Silicon content over 309L for fluidity.

#### BASE MATERIALS

All 300 series Austenitic Stainless Steel, Overlay of Mild Steel (Cladding)  
Joining of Austenitic Manganese Steels (Hadfields), 3Cr12 and for dissimilar applications.

#### MECHANICAL PROPERTIES

~600n/mm UTS n/mm	>380 YIELD 0.2%	>30 ELONG A5%	>40 CV (J) -196°C
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#### METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo	S	P	Fe
0.02	0.6	1.9	23.5	12.5	0.05	0.002	0.02	BAL

#### PACKAGING

15kg Spools (MIG)  
5kg Tubes (TIG)

#### DIAMETERS

0.8, 1.0, 1.2mm (MIG)  
1.6, 2.4, 3.2mm (TIG)

#### WELDING INSTRUCTIONS

Shielding gas 5% or 20% CO<sub>2</sub> in Argon, or 2% Argon-Ox (MIG), 100% Argon (TIG). Do not allow the base material to overheat, maintain interpass temperature below 150°C.

**For more details on welding of Stainless steel, please see our Information Sheets.**  
**Visit:** [www.westbrookwelding.co.uk/downloads](http://www.westbrookwelding.co.uk/downloads)