

# Gas Metal Arc Welding

JIS -  
AWS A5.9 ER309LSi  
DIN 8556-SG 1.4332

## MS M-309LSi Solid Wires for Stainless Steel

**Applications** Suitable for dissimilar-metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals. Usage as MS M-309L, but the 0.65-1.0% silicon content improves wetting behavior in the gas shielded welding process.

Brand Name		MS M-309LSi							
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.030	≤ 0.65 1.00	1.0- 2.5	≤ 0.03	≤ 0.03	12.0- 14.0	23.0- 25.0	-	-
<b>Mechanical property of deposited metal</b>									
Tensile strength	≥ 510 N/mm <sup>2</sup>								
0.2% Offset strength	≥ 205 N/mm <sup>2</sup>								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -196° C 49 J								
Welding position	Horizontal/Flat position								
Welding polarity	DC-EP								
Shielding gas	98%Ar - 2%O <sub>2</sub>								
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm				
	80-180A	120-200A	140-250 A	170-300 A	200-350A				
Packing	12.50 kgs standard other packing weight can be provided upon request.								