

Gas Tungsten Arc Welding

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

MS T-309LSi Filler Rod 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 T-309LSi							
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Chemical composition of length	1000 mm Standard or 950 mm Upon requested.								
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	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 540 N/mm ²								
0.2% Offset strength	≥ 225 N/mm ²								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -0 °C 80J								
Welding position	All position								
Welding polarity	DC-EN								
Shielding gas	Ar								
Welding current	Dia. 1.2 mm		Dia. 1.6 mm			Dia. 2.4 mm			
	30-80 A		40-120 A			50-150 A			
Packing									
Inner case weight (kg)	5.00								