

XP ER 309LSi

STAINLESS STEEL



CLASSIFICATIONS

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

KEY FEATURES AND APPLICATIONS

- Solid corrosion resistant chromium-nickel wire for welding of similar steels, wrought and cast steels of 23% Cr-12% Ni types.
- Well-suited for depositing intermediate layers when welding clad materials.
- The increased silicon content promotes weld pool fluidity to give a smooth deposit appearance.
- Ideal for service temperature up to 300°C max.
- Typically used for welding buffer layers on CMn steels and welding of dissimilar joints.

BASE MATERIALS

42CrMo4, C45, 42MnV7, tool steels etc, 1.2780, 1.4541, 1.4550, 1.4710, 1.4712, 1.4713, 1.4724, 1.4729, 1.4740, 1.4741, 1.4742, 1.4746, 1.4762, 1.4745, 1.4825, 1.4826, 1.4828, 1.4832, 1.4878, X15CrNiSi20 12, G-X 40 CrNiSi209, AISI 446, AISI442, AISI309, UNS S30900, UNS S44200, UNS S4460

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
MIN	-	0.65	1.0	-	-	22.0	11.0	-	-
MAX	0.03	1.2	2.5	0.03	0.02	25.0	14.0	0.5	0.5

Single values are maximum values according to EN ISO 14343

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)
495 (≥320)	635 (≥510)	36 (≥25)

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - M12, M13	DC+

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP30226	0.8	BS300	15	72
XP30228	1.0	BS300	15	72
XP30230	1.2	BS300	15	72