

TIGWELD 309LSi

TIG Rods [GTAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : W 23 12 LSi DIN 8556 : SG-X2 CrNi24 12 AWS A-5.9 : ER 309 LSi W.Nr. : 1.4332		Power generation industry Constructions & Engineering Petrochemical and chemical industry Shipbuilding&Offshore

Stainless steel welding rods. Recommended for similar and dissimilar joints, for example 18-8 with carbon steel, low alloyed or mild alloyed steels. The rods can be used for the materials working in the temperature up to 1000°C.

Base material

AISI/ASTM	DIN	W.Nr.
	G-X25 CrNiSi 18 9	1.4825
	G-X40 CrNiSi22 9	1.4826
309	X15 CrNiSi20 12	1.4828
	G-X25 CrNiSi20 14	1.4832
304	X5 CrNi18 10	1.4301
304L	X2 CrNi18 11	1.4306
305	G-X10CrNi18 8	1.4312
304LN	X2 CrNi18 10	1.4311
321	X10 CrNiTi18 9	1.4541
347	X6 CrNiNb18 10	1.4550
	X10 CrSi6	1.4712
	X10 CrAl13	1.4724
	X10 CrAl18	1.4742
High alloyed steels		
High tensile steels		
Austenitic-manganese steels		
Difficult to weld steels		

Chemical composition %

C	Si	Mn	Cr	Ni
<0,025	0,80	1,60	23,50	13,50

Mechanical properties

Yield strength Re [N/mm²]	>380
Tensile strength Rm [N/mm²]	550-700
Elongation A5 [%]	>22
Impact energy Kv [J]	>27J (-196°C) /
Shielding gases acc. to EN ISO 14175	I1 - Ar /