

OK Tigrod 309LSi

GTAW
ER309LSi

Description

Bare, corrosion-resistant, chromium-nickel welding rod for welding steels with similar composition, wrought and cast steels of the 23% Cr-12% Ni types. The alloy is also used for welding buffer layers on CMn steels and for welding dissimilar joints. When using the wire for buffer layers and dissimilar joints, it is necessary to control the dilution of the weld.

OK Tigrod 309LSi has good general corrosion resistance. The higher silicon content improves the welding properties such as wetting.

Welding current

DC(-)

Classifications

SFA/AWS A5.9	ER309LSi
EN 12072	W 23 12 LSi
Werkstoffnummer	~1.4332

Wire composition

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.8	1.8	24.0	13.0	<0.3	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	475
Tensile strength, MPa	635
Elongation, %	32

Charpy V

Test temps, °C	Impact values, J
+20	150
-60	130
-110	80

Approvals

UDT VdTÜV	DIN 8556
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Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.2	1000	5.0
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0