

Lincoln® TIG 309LSi

Key Features

- High silicon for improved wetting
- Double stamped for optimum traceability

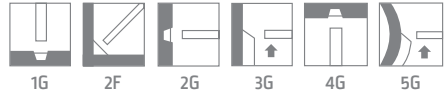
Typical Applications

- Excellent for welding dissimilar metals e.g. stainless steel to carbon steel
- Build up welding on mild and low alloy steels
- Buffer layers before hard facing

Conformances

AWS A5.9: ER309LSi

Welding Positions



Shielding Gas

- 100% Argon
- Flow rate 10-15 L/min

Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
1.6	1000	365291	PE Tube 2kg
2.4	1000	365292	PE Tube 2kg

Mechanical Properties - As required per AWS A5.9

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -46°C
Typical Results - As Welded	410	570	35	65

Deposit Composition

	%C	%Mn	%Si	%Ni	%Cr	%Mo
Typical Results - As Welded	0.017	1.6	0.8	13.5	23.0	0.1