LNM 309LSi

TOP FEATURES

- The weld metal has a delta-ferrite content of ~12% resulting in a high resistance to hot cracking.
- The increased silicon content results in increased weld pool fluidity to give a smooth deposit appearance.
- Also used for the welding of clad steels where service temperatures are below 300°C.

CLASSIFICATION

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

SHIELDING GASES (ACC. EN ISO 14175)

M12	Mixed gas Ar+ 0.5-5% CO_2
M13	Mixed gas Ar+ 0.5-3% O_2

TYPICAL APPLICATIONS

- General fabrication
- Transport
- Process Industries

APPROVALS

DNV	TÜV	DB	CE
+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	Cr	Ni	Mo
0.02	1.8	0.8	23.3	13.8	0.14

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						+20°C	-20°C
Typical values	M12	AW	436	582	37	87	80

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
0.8	SPOOL (BS300)	15.0	581669
0.9	SPOOL (BS300)	15.0	581770
1.0	SPOOL (BS300)	15.0	595789
	DRUM	250.0	581708
1.2	SPOOL (BS300)	15.0	595796
	DRUM	250.0	581710

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.