

Lincoln® MIG 309LSi

Key Features

- High silicon level for increased puddle fluidity, better bead shape and edge wetting
- Precision layer wound wire assists feeding and resists wire tangles

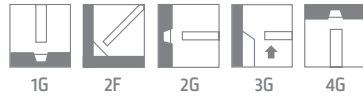
Typical Applications

- Ideal for welding carbon steels to stainless steels
- For welding UNS 309 and 309L austenitic grades S30900 and S30908
- Good as a buffer layer in many hardfacing applications

Conformances

AWS A5.9/A5.9M: ER309LSi

Welding Positions



Shielding Gas

- 98-99% Argon / 1-2 % O₂ (spray transfer)
- 98-99% Argon / 1-2% CO₂ (short circuit)
- Flow Rate: 15-20 L/min

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS ipm	Voltage volts	Current amps	CTWD mm
0.9	331099	Spool S300 15kg	120-475	18-22	60-160	10-15
1.2	331092	Spool S300 15kg	125-360	19-23	100-185	10-20

Mechanical Properties - As required per AWS A5.9

	Yield Strength MPa	Tensile Strength MPa	Elongation %	FN WRC
Requirements - AWS ER309LSi	Not specified	Not specified	Not specified	Not specified
Typical Results	400	580	39	8-11

Wire Composition

	%C	%Mn	%Si	%Cr	%Ni
Typical Results	0.02	1.9	0.76	23.8	13.7