

Primalloy® JMS-309LSi

Key Features

- Excellent weldability – Stable arc, low spatter, good wetting and fluidity brings outstanding bead appearance
- Superb feedability – Unique manufacturing technology results in an even clean wire surface, stable wire feeding and low contact tip abrasion

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

- Ar + 2-5% CO₂

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts	Current amps	CTWD mm
0.9	EMLM39LS090S015W00	Spool S300 15kg	60-475	19-25	60-210	10-15
1.2	EMLM39LS120S015W00	Spool S300 15kg	60-475	19-25	60-210	15-20

Mechanical Properties - As required per AWS A5.18

	Yield Strength MPa	Tensile Strength MPa	Elongation %
Typical Results [95%Ar / 5% CO ₂]	430	600	43

Deposit Composition

	%C	%Si	%Mn	%P	%S
Typical Results	0.01	0.86	1.75	0.01	0.01
	%Cr	%Mo	%Ni	%Cu	
	23.7	0.02	13.5	0.01	