

# LINCOLN® ER309Si/309LSi

Stainless ▪ AWS ER309Si, ER309LSi

## KEY FEATURES

- High silicon level for increased puddle fluidity and wetting out at the toes
- Excellent weld contour minimizes the need for grinding
- Solid rod for welding stainless steel to carbon steel
- Q2 Lot® Tested - A certificate showing actual wire composition and calculated ferrite number (FN) is available online
- Electrode identification is ink jet printed on the entire length of the electrode

## WELDING POSITIONS

All

## CONFORMANCES

**AWS A5.9:2017** ER309Si, ER309LSi  
**ASME:** SFA-5.9

## TYPICAL APPLICATIONS

- Designed for joining stainless to mild or low alloy steel

## SHIELDING GAS

GTAW: 100% Ar

## DIAMETERS / PACKAGING

Diameter in (mm)	10 lb (4.5 kg) Plastic Tube 30 lb (13.6 kg) Master Carton
3/32 (2.4)	ED037113
1/8 (3.2)	ED037114
5/32 (4.0)	ED037115

## WIRE COMPOSITION<sup>(1)</sup> – As Required per AWS A5.9/A5.9M

	%C	%Cr	%Ni	%Mo	%Mn	%Si	%P	%S	%Cu	Total Others
<b>Requirements -</b> AWS ER309LSi	0.03 max	23.0-25.0	12.0-14.0	0.75 max	1.0-2.5	0.65-1.00	0.03 max	0.03 max	0.75 max	Info Only
<b>Typical Results<sup>(1)</sup></b>	0.01	23.4	13.8	0.03	1.9	0.78	0.02	0.01	0.04	0.05
<b>Requirements -</b> AWS ER309Si	0.12 max	23.0-25.0	12.0-14.0	0.75 max	1.0-2.5	0.65-1.00	0.03 max	0.03 max	0.75 max	Info Only
<b>Typical Results<sup>(1)</sup></b>	0.01	23.4	13.8	0.03	1.9	0.78	0.02	0.01	0.04	0.05

<sup>(1)</sup>See test results disclaimer

## FERRITE NUMBER (FN)

	FN - WRC1992 C
<b>Requirements -</b> AWS ER309LSi	Info. Only
<b>Test Results<sup>(1)</sup></b>	11
<b>Requirements -</b> AWS ER309Si	Info. Only
<b>Test Results<sup>(1)</sup></b>	10

<sup>(1)</sup>See test results disclaimer

*Safety Data Sheets (SDS) and Certificates of Conformance are available on our website at [www.lincolnelectric.com](http://www.lincolnelectric.com)*

FUMES AND GASES can be hazardous to your health.

- Fumes from the normal use of this product contain significant quantities of potentially hazardous compounds. See consumable product label/insert.
- Keep your head out of the fumes.
- Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area.
- An approved respirator should be used unless exposure assessments are below applicable exposure limits.

### 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.

### CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com](http://www.lincolnelectric.com) for any updated information.