

LNT 309LSi

TOP FEATURES

- Also used for the welding of clad steels where service temperatures are below 300°C.
- 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.

TYPICAL APPLICATIONS

- General fabrication
- Cladding

CLASSIFICATION

AWS A5.9 ER309LSi
EN ISO 14343-A W 23 12 LSi

SHIELDING GASES (ACC. EN ISO 14175)

I1 Inert gas Ar (100%)

APPROVALS

DNV	TÜV	CE
+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	Cr	Ni	Mo
0.02	2.0	0.8	23.5	13	0.1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -120°C
Typical values	I1	AW	400	600	35	65

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
1,2	PE Tube	5.0	606008
1,6	PE Tube	5.0	604405
2,0	PE Tube	5.0	604566
2,4	PE Tube	5.0	604641
3,2	PE Tube	5.0	604665

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.

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