

MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 309LSi is a stainless steel solid wire with 25%Cr 12%Ni, low carbon content. The increased Si level gives excellent weldability. Inertfil 309LSi is suitable for welding austenitic stainless steels similar to AISI 309. It is also used for welding dissimilar steels and for buffer layers.

Classification	
AWS	A5.9: ER 309L Si
EN	12072: G 23 12 L Si

Approvals	Grades
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Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.02	1.80	0.85	≤ 0.030	≤ 0.020	24	13	-	-	-	-	10-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 350	≥ 520	≥ 30	≥ 47	-

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1)

Materials

A312 TP309S; carbon steel to stainless steels joint

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+				
				
PA	PB	PC	PF	PE

Packaging data: BS300 Kg. 15

Diameters	0,8	1,0	1,2	1,6		