

OK Autrod 309LSi

A continuous solid corrosion resistant chromium-nickel wire for welding of similar steels, wrought and cast steels of 23% Cr-12% Ni types. The alloy is also used for welding of buffer layers on CMn steels and welding of dissimilar joints. When using the wire for buffer layers and dissimilar joints it is necessary to control the dilution of the weld. OK Autrod 309LSi has a good general corrosion resistance. The higher silicon content improves the welding properties, such as wetting.

Classifications Wire Electrode:	EN ISO 14343-A:G 23 12 L Si, SFA/AWS A5.9:ER309LSi, Werkstoffnummer :~1.4332
Approvals:	CE EN 13479, NAKS/HAKC 1.0MM-1.2MM, CWB ER309LSi, DB 43.039.16, VdTÜV 10020

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type:	Austenitic (with approx. 8 % ferrite) 24 % Cr - 13 % Ni - Low C
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	440 MPa	600 MPa	41 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As welded	20 °C	160 J
As welded	-60 °C	130 J
As welded	-110 °C	90 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Ferrite FN
0.02	1.7	0.9	13.5	23.4	0.15	0.12	9

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	55-160 A	15-24 V	4.0-17.0 m/min	1.0-4.1 kg/h
0.9 mm	65-220 A	15-28 V	3.5-18.0 m/min	1.1-5.4 kg/h
1.0 mm	80-240 A	15-28 V	4.0-16.0 m/min	1.5-6.0 kg/h
1.2 mm	100-300 A	15-29 V	3.0-14.0 m/min	1.6-7.5 kg/h
1.6 mm	230-375 A	23-31 V	5.5-9.0 m/min	5.2-8.6 kg/h