

# **SMT-309LSi INOX**

**AWS A5.9/ ASME SFA5.9 ER 309LSi**

**EN 14343 – G/W 23.12. L. Si**



## ❖ Specification

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EN 14343-G/W 23.12. L. Si

## ❖ Approvals

TUV, CE Marking

## ❖ Applications

SMT-309LSi INOX is a high alloy 23 Cr 12 Ni wire primarily used for surfacing of low alloy steels & dissimilar welding between mild steel / ferritic steels to austenitic stainless steels. The high alloy content and higher ferrite content offers a ductile and crack resistant weldment. The higher silicon content gives better arc stability and weld fluidity.

## ❖ Corrosion resistance

Superior to type 308L. When surfacing on mild steel a corrosion resistance equivalent to ASTM 304 is obtained at the first run.

## ❖ Ferrite Content

Ferrite Number about 11 – WRC-92

## ❖ Welding Parameters

Welding Current DC-

## ❖ Shielding Gas

I1 Pure Argon 5-10 L/min, M13 Argon+1-3% O2 5, 5-10 L/min

## ❖ Typical Chemical Composition of Wire

	C %	Mn %	Si %	Cr %	Ni %	S %	P %	Mo %
Min	-	1.0	0.65	23	12	-	-	
Max	0.03	2.5	1.00	25	14	0.03	0.02	0.30

## ❖ Typical Mechanical Properties (as Weld)

Yield Strength	Tensile Strength	Elongation on % A5	Hardness	Impact Energy(20°C)	Impact Energy(-196°C)
(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	%	BHN	Joule	Joule
400	650	35	200	120	55



## ❖ Packaging Detail

Diameter (mm) *	0.8, 1.0, 1.2, 1.6
Packing **	12.5kg(25lbs), 15kg(20-33lbs) Layer Wound plastic spools i.e. SD300, Metallic basket (K300). 5kg(10lbs) layer wound plastic spools i.e. SD200. 1kg(2lbs) layer wound plastic spools i.e. SD100. Drum pack 100kgs and 250kgs (0.8, 1.0, 1.2mm)

\* Also available in AWS standard diameters.

\*\* Available in Customized packing / Neutral packing on request.