

Specifications:

AWS A5.9
 AWS Class ER309LSi
 ASME SFA 5.9
 UNS S30988

Properties:

Tensile Strength: 89,900 psi
Yield Strength: 60,500 psi
Elongation: 35%

Description:

ER309LSi is similar to ER309L except it contains a higher silicon content which gives it improved wetting action. This alloy is good for general purpose GMAW welding, providing a smooth weld profile in welding applications of stainless steel plate and sheets. This alloy could have a somewhat higher crack sensitivity than other alloys with a lower silicon content, if the dilution of the base metal creates a fully austenitic weld or a low ferrite. ER309LSi contains a lower carbon content which allows for a reduction in the likelihood of intergranular carbide precipitation, and it has a higher resistance to intergranular corrosion. ER309LSi is best used in the welding of food service applications and beverage tanks.

Available in multiple sizes and diameters

Chemical Composition (Wt%)

Si	Mn	Cu	Mo	S	Ni	Cr	P	C
0.65-1.0	1.0-2.5	0.75	0.75	0.03	12.0-14.0	23.0-25.0	0.03	0.03

Note: Single values are maximum unless otherwise noted.

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.