



CEWELD 309LSi Tig

TYPE	Stainless steel filler metal for dissimilar welding between steel and stainless steel and difficult to weld steels.(Type 1.4432, 23 12 LSi)																	
APPLICATIONS	CEWELD 309LSi Tig is for buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.																	
PROPERTIES	High mechanical properties and very good weldability due to a ingreased silicon content, suitable for operating temperatures from -120°C up to 300°C.																	
CLASSIFICATION	AWS	A 5.9: ER309LSi																
	EN ISO	14343-A: W 23 12 L Si																
	W.Nr.	1.4432																
	F-nr	6																
	FM	5																
SUITABLE FOR	ISO 15608: 8.1 Austenitic ≤ 19 % Cr (no Mo) ISO 15608: Gr. 8.1 mix 1.1 1.2780, 1.4541, 1.4550, 1.4710, 1.4712, 1.4713, 1.4724, 1.4729, 1.4740, 1.4741, 1.4742, 1.4746, 1.4762, 1.4745, 1.4825, 1.4826, 1.4828, 1.4832, 1.4878, X15CrNiSi20 12, G-X 40 CrNiSi20 9, AISI 446, AISI442, AISI309, UNS S30900, S44200, S44600																	
APPROVALS	TÜV: (12394), CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.7</td> <td>1.7</td> <td>0.01</td> <td>0.01</td> <td>24</td> <td>13</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	0.02	0.7	1.7	0.01	0.01	24	13			
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MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>535</td> <td>640</td> <td>37</td> <td>140</td> <td>50</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT	-196°C	As Welded	535	640	37	140	50	HRc	
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		RT	-196°C															
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REDRYING	Not required																	
GAS ACC. EN ISO 14175	I1																	



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309LSI TIG 1,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663413987
309LSI TIG 1,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414007
309LSI TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663413994
309LSI TIG 1,6 X 500MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414014
309LSI TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414021
309LSI TIG 2,0 X 500MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414045
309LSI TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414069
309LSI TIG 2,4 X 500MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414083
309LSI TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414090
309LSI TIG 4,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663414182