



Nevatia Steel & Alloys Pvt. Ltd.  
Office : 904,Lodha Supremus,9<sup>th</sup> floor  
Worli, Mumbai ,India - 400018.  
Web:<http://www.nevatiasteel.com>



TD-Stainless Welding wire  
Revision No.: 02  
Date of Issue : 01.11.2019

IATF 16949 , ISO 9001, ISO 14000 and ISO 45001 Certified Company

## Stainless steel welding wire -Technical data

**Product Name :** nevinox<sup>®</sup>MIG309LSi

**Product Specifications :** ER 309LSi

Grade	Equivalent Standards		
	AWS A5.9/5.9M	EN ISO 14343 A	EN ISO 14343 B
ER 309LSi	ER 309LSi	23 12 L Si	309LSi

**Characteristics:** ER 309LSi is austenitic Stainless steel welding wire, the weld metal contains ferrite and resistance to crack is extremely good. Due to its high level of alloy, it has excellent resistance to heat.

### Application:

ER 309LSi welding wire of 22%Cr-12%Ni steel for joining ferrite to austenite stainless steel for services temperature up to 300°C . Heat resistance cast steel clad side of 18% Cr-8% Ni clad steel and stainless steel to Cr-Mo steel or carbon steel.

### Chemical Composition % (Solid wire)

C	Mn	P	S	Si	Cr	Ni	Mo	Cu
0.03	1.40 - 2.10	0.030	0.020	0.65 - 1.00	23.00 - 25.00	12.00 - 14.00	0.30	0.30

**Remarks:** Single values shown in the table are maximum values. Two values shown indicate minimum and maximum limits for a range.

### Typical All weld Mechanical properties

Product	Grade	Shielding Gas	N/mm <sup>2</sup>		% EL (GL=50mm)	Impact Value (Joules)			
			YS (0.2% PT)	TS		-20°C	-60°C	-101°C	-196°C
MIG	ER 309LSi	M21	495	656	35	-	-	128	-
MIG	ER 309LSi	M12	444	636	34	-	-	63	-

**Current Conditions:-** DC (+)

**Welding position:-**





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## Dimension & Packing Data

Size(mm)	Size(inch)	SD100 Spool packing 1kg/2lb	SD200Spool packing 5kg/10lb	SD300/BS300 Spool packing 12.5kg,15kg /25lb, 33lb	Drum packing 100kg,250kg/ 200lb, -550 lb
0.600	0.024	√	√	-	-
0.800	0.030	√	√	√	√
0.900	0.035	√	√	√	√
1.000	0.040	√	√	√	√
1.200	0.045	√	√	√	√
1.600	0.063	-	√	√	√

## Diameter tolerance and ovality

- As per AWS A5.9 and ISO 544

## Inspection & certification

- As per EN 10204 type 3.1

## Approvals :



For more details please contact : [sales@nevatiasteel.com](mailto:sales@nevatiasteel.com).