



Product Data Sheet

G 'Gas-shielded metal-arc welding'

AlloyRod 309LSi MIG

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REASON FOR ISSUE

New Product

GENERAL

AlloyRod 309LSi is a solid corrosion resisting 24%Cr- 12% Ni wire for welding similar alloys, as buffer layer on C-Mn steels and for some dissimilar joints. The higher Si content improves welding properties such as wetting and fluidity.

Shielding Gas: M12, M13 (EN ISO 14175)

Alloy Type: Austenitic 24%Cr- 13%Ni-Low C- High Si

CLASSIFICATIONS Wire Electrode

EN ISO 14343-A G 23 12 L Si
SFA/AWS A5.9 ER309LSi

APPROVALS

CE EN 13479
UKCA EN 13479

CHEMICAL COMPOSITION

All Weld Metal (%) Wire/Strip (%)

	Nom	Min	Max	Nom
C	0.025		0.03	0.025
Si	0.90	0.65	1.00	0.90
Mn	1.8	1.0	2.5	1.90
P	0.025		0.03	0.025
S	0.010		0.02	0.010
Cr	23.4	23.0	25.0	23.50
Ni	12.50	12.0	14.0	12.50
Mo	0.05		0.5	0.05
Nb	0.005			0.005
Cu	0.10		0.5	0.10
N	0.10			0.120
FN WRC-92	8			8
Ferrite FN	5			

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Standard	Condition	Rp0.2 [MPa/ksi]		Rm [MPa/ksi]			A4 [%]		A5 [%]	
		Min	Typ	Min	Max	Typ	Min	Typ	Min	Typ
AWS	As welded		580/84	520/75		680/99	30	35		
EN ISO	As welded	320/46	550/80	510/74		650/94			25	35

Comments:

Standard	Condition	Temp [°C/°F]	Charpy V [J/ft-lb]	
			Min	Typ
AWS	As welded	20/68 -196/-321		140/104 60/44
EN ISO	As welded	20/68 -196/-321		140/104 60/44

Comments:

