


<b>CATEGORY</b>	GMAW-GTAW Solid wires																																		
<b>TYPE</b>	Solid stainless steel welding wire for dissimilar welding																																		
<b>APPLICATIONS</b>	Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.																																		
<b>PROPERTIES</b>	High mechanical properties and very good weldability due to a ingreased silicon content, suitable for operating temperatures up to 300°C.																																		
<b>CLASSIFICATION</b>	AWS	A 5.9: ER309LSi																																	
	EN ISO	14343-A: G 23 12 L Si																																	
	F-nr	6																																	
	FM	5																																	
	W.Nr.	1.4332																																	
<b>SUITABLE FOR</b>	Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels such as: 42CrMo4, C45, 42MnV7, tool steels etc.																																		
<b>APPROVALS</b>	TÜV (12395.00) CE																																		
<b>WELDING POSITIONS:</b>																																			
<b>TYPICAL WELD DEPOSIT WEIGHT %</b>	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.8</td> <td>1.3</td> <td>24.1</td> <td>12.85</td> </tr> </tbody> </table>					C	Si	Mn	Cr	Ni	0.02	0.8	1.3	24.1	12.85																				
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<b>REDRYING TEMPERATURE</b>	Not required																																		
<b>GAS ACCORDING EN 14175</b>	M11, M13, M12																																		