

Product Data Sheet

SUPERTIG 309LSi

SS TIG WELDING WIRE
Stainless and Heat resistant steels

Classification :

AWS A 5.9 : ER 309 LSi
EN 12072 : W 23 12 LSi

Description: SUPERTIG 309LSi is a stainless TIG rod conforming to ER 309LSi for welding austenitic stainless steels such as AISI 309LSi. It is also used to weld dissimilar steels and for buffer layers and buttering 18 Cr/ 8 Ni steels. Excellent oxidation and corrosion resistance in continuous service up to 1100°C. Ferrite content is 15% approx. Si-0.85% approx content improves weldability and bead appearance

Materials to be welded

A312 TP309S; carbon steel to stainless steels joint .

Typical Chemical Composition (%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.03 max	1.50-2.20	0.65-1.00	23.00-25.00	12.00-14.00	0.75 max.	0.75 max.	0.03 max.	0.03 max.

Typical All Weld Mechanical Properties

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO-V(J) 20° C
≥ 350	≥ 520	≥ 30	≥ 47

Current Conditions: - DC (-)

Storage: - Keep dry and avoid condensation.

Welding Position:-



Packing Data

Size(mm) DxL	0.80 x 1000	0.90 x 1000	1.00 X1000	1.20 X 1000	1.60 x 1000	2.00 x 1000	2.40 x 1000	3.20 x 1000	4.00 x 1000
Net wt. per tube(kg)	5	5	5	5	5	5	5	5	5
Net wt. per Box(kg)	20	20	20	20	20	20	20	20	20
