



S. R. Industries

STAR ARC ER309LSI

ER309LSI is similar in composition to ER309L with a higher silicon content, which produces weld beads that are exceptionally smooth due to good wetting action. 309LSI is a great choice when cosmetic appearance is important.

AWS Specification : AWS A5.9/A5.9M:2006

<i>AWS Classification</i>	ER309LSI
<i>Welding Current</i>	DCEP
Typical Wire Chemistry	
<i>C</i>	0.03
<i>Cr</i>	23.0 - 25.0
<i>Ni</i>	12.0 - 14.0
<i>Mo</i>	0.75
<i>Mn</i>	1.0 - 2.5
<i>Si</i>	0.65 - 1.00
<i>P</i>	0.03
<i>S</i>	0.03
<i>Cu</i>	0.75
Typical Mechanical Properties (As Welded)	
<i>Yield Strength, ksi</i>	64
<i>Tensile Strength, ksi</i>	84

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<i>Elongation%, min</i>	<i>41</i>
<i>Welding Positions</i>	<i>F,V,OH,H</i>
<i>Available Diameters MIG with Operating Range in Amps</i>	
<i>.023"</i>	<i>35 - 70</i>
<i>.030"</i>	<i>50 - 100</i>
<i>.035"</i>	<i>100 - 150</i>
<i>.045"</i>	<i>150 - 200</i>
<i>Available Diameters TIG with Operating Range in Amps</i>	
<i>.035"</i>	<i>60 - 90</i>
<i>.045"</i>	<i>80 - 110</i>
<i>1/16"</i>	<i>90 - 130</i>
<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>
<i>5/32"</i>	<i>170 - 350</i>

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