

Standards

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|-------------------|----------------|
| TS EN ISO 14343-A | : G 23 12 L Si |
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| AWS A5.9 | : ER 309 L Si |

Chemical Composition of Welding Wire % (Typical)

| C | Si | Mn | Cr | Ni |
|------|------|------|------|------|
| 0.03 | 0.80 | 1.80 | 23.5 | 13.0 |

Mechanical Properties

| Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Impact Strength (ISO-V/+20 °C) | Elongation ((L ₀ =5d ₀) (%)) |
|--|--|-----------------------------------|--|
| min. 320 | min. 520 | min. 47 J | min. 30 |

Typical Base Material Grades

- Ferritic Cr and austenitic CrNi steels, austenitic manganese steels, unalloyed high strength steels, high temperature steels.

Features and Applications

- Applicability on ferritic Cr or austenitic CrNi steels, austenitic manganese steels, unalloyed high-strength steels, heat-treated steels
- Usability in welding austenitic stainless steels, in joint- welding of different kinds of metals, in buffer layers, in joint-welding of corrosion-resistant stainless steels to each other or to low-alloyed steels, and in welding coated steels
- Ar+ %2.5 O₂ or (Ar+%2.5 CO₂) gas is used as shielding gas

Welding Positions



Current Type

MIG D.C.(+)

Operating Data

| Product Code | Diameter (mm) / (inch) | | Weight (Kg) | Package Type |
|--------------|---------------------------|--------|----------------|--------------|
| 6011100383 | 0.8 | 0.030" | 12.5 | BS 300 |
| 6011100331 | 1.0 | 0.040" | 15 | BS 300 |
| 6011100332 | 1.2 | 0.047" | 15 | BS 300 |

Approvals: CE, SEPRO