

OK Tigrod 309LSi

Bare corrosion resistant chromium-nickel welding rod for welding of similar steels, wrought and cast steels of 23% Cr-12% Ni types. The alloy is also used for welding of buffer layers on CMn steels and welding of dissimilar joints. When using the wire for buffer layers and dissimilar joints it is necessary to control the dilution of the weld. OK Tigrod 309LSi has a good general corrosion resistance. The higher silicon content improves the welding properties, such as wetting.

Specifications	
Classifications	EN ISO 14343-A : W 23 12 L Si SFA/AWS A5.9 : ER309LSi
Approvals	CE : EN 13479 DB : 43.039.17 NAKS/HAKC : 2.4MM VdTUV : 12489

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 8 % ferrite) 24 % Cr - 13 % Ni - Low C
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	475 MPa (69 ksi)	610 MPa (88 ksi)	35 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C (68 °F)	150 J (111 ft-lb)
0 °C (32 °F)	150 J (111 ft-lb)
-60 °C (-76 °F)	150 J (111 ft-lb)
-110 °C (-166 °F)	130 J (96 ft-lb)

Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.016	1.9	0.7	0.004	0.019	13.7	23.3	0.1	0.1	0.09

Typical Wire Composition %	
FN WRC-92	
9	

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.8	0.7	0.003	0.015	13.5	23	0.1	0.1	0.09

Typical Weld Metal Analysis %	
Nb	FN WRC-92
0.01	8