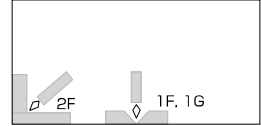


## Solid wire

**Features:** ■ Suitable for dissimilar-metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals

**Welding Positions:**

**Classification:** AWS A5.9 ER309LSi

**Shielding gas:** Ar-2%O<sub>2</sub>

**Polarity:** DCEP

**Packaging data**

φ mm	Spool	
	10kg	20kg
1.2	240W, 110H, 240L	285W, 110H, 285L

**Composition (wire mass%)**

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.02	0.03
<b>Si</b>	0.84	0.65~1.00
<b>Mn</b>	1.8	1.0~2.5
<b>P</b>	0.02	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	13.3	12.0~14.0
<b>Cr</b>	23.6	23.0~25.0
<b>Mo</b>	0.03	0.75
<b>Cu</b>	0.03	0.75

**Welding parameters (A)**

φ mm	1F, 1G, 2F
1.2	100~300

Note: <sup>a</sup>Single values are maximum.

**All-weld mechanical properties**

	Typical
<b>0.2%YS (MPa)</b>	410
<b>TS (MPa)</b>	570
<b>EI on 4d (%)</b>	40
<b>IV 0°C (J)</b>	88