

# TECHNICAL DATA SHEET



## Super6 309LSi MIG

AWS A 5.9 :ER 309LSi  
EN ISO 14343-A G 23 12 LSi  
Date-20.05.24 Revision 1

### DESCRIPTION

A Low carbon 25Cr 12Ni stainless solid wire suitable for welding austenitic stainless steels such as AISI 309. Super6 309LSi is used for welding mild and medium tensile steels to stainless often for depositing intermediate layers on steel prior to depositing 308 grade .Applications include clad steels where service temperatures are below 300°C, its also resistant to hot cracking. The increased silicon level results in excellent weld pool fluidity giving a smooth bead appearance.

### WELDING POSITIONS

PA PB PC PF PE PF2

### CHEMICAL COMPOSITIONS

C	Mn	Si	Cr	Ni
0.03 max	1.50 2.20	0.65 1.00	23.00 25.00	12.00 14.00

### MECHANICAL PROPERTIES

Yield Strength	≥ 350
UTS N/mm <sup>2</sup>	≥ 550
Elongation A5 %	≥ 30

### AVAILABLE FORMATS

SPOOL		
Diameter	5.0kg	15.0kg
0.8mm	7193	7195
1.0mm	7194	7196
1.2mm		7197

Shielding Gas	Argon 2% O <sub>2</sub>
Current Type	DC +

While all reasonable efforts have been made to ensure the accuracy of this information, it may change at any time and is only intended as general guidance.

# TECHNICAL DATA SHEET



## Super6 309L TIG

AWS A 5.9 :ER 309L  
EN ISO 14343-A W 23 12 L  
Date-20.05.24 Revision 1

### DESCRIPTION

A Low carbon 25Cr 12Ni stainless solid wire suitable for welding austenitic stainless steels such as AISI 309. Super6 309L is used for welding mild and medium tensile steels to stainless often for depositing intermediate layers on steel prior to depositing 308 grade .Applications include clad steels where service temperatures are below 300°C, its also resistant to hot cracking.

### WELDING POSITIONS

PA PB PC PF PE PF2

### CHEMICAL COMPOSITIONS

C	Mn	Si	Cr	Ni
0.03 max	1.50 2.20	0.65 1.00	23.00 25.00	12.00 14.00

### MECHANICAL PROPERTIES

Yield Strength	≥ 350
UTS N/mm <sup>2</sup>	≥ 550
Elongation A5 %	≥ 30

### AVAILABLE FORMATS

TUBE	
Diameter	5.0kg
1.6mm	7219
2.4mm	7220
3.2mm	7221

Shielding Gas	Argon
Current Type	DC -

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