

LNM 309LSi

TOP FEATURES

- The weld metal has a delta-ferrite content of ~12% resulting in a high resistance to hot cracking.
- The increased silicon content results in increased weld pool fluidity to give a smooth deposit appearance.
- Also used for the welding of clad steels where service temperatures are below 300°C.

TYPICAL APPLICATIONS

- General fabrication
- Transport
- Process Industries

CLASSIFICATION

AWS A5.9 ER309LSi
EN ISO 14343-A G 23 12 L Si

SHIELDING GASES (ACC. EN ISO 14175)

M12 Mixed gas Ar+ 0.5-5% CO₂
M13 Mixed gas Ar+ 0.5-3% O₂

APPROVALS

DNV	TÜV	DB	CE
+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	Cr	Ni	Mo
0.02	1.8	0.8	23.3	13.8	0.14

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)
						+20°C -20°C
Typical values	M12	AW	436	582	37	87 80

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
0.8	SPOOL (BS300)	15.0	581669
0.9	SPOOL (BS300)	15.0	581770
	SPOOL (BS300)	15.0	595789
1.0	SPOOL (S300)	15.0	595792
	DRUM	250.0	581708
	SPOOL (BS300)	15.0	595796
1.2	SPOOL (S300)	15.0	595794
	DRUM	250.0	581710
1.6	SPOOL (BS300)	15.0	581706

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.