

KM-309LSi

Classification

Shielding Gas:	Ar+1~2%O ₂	AWS A5.9/A5.9M	ER309LSi
	Ar+1~2%CO ₂	AS/NZS ISO 14343	B SS309LSi

Applications and Features

- (1) Weld metal is austenite structure with low carbon 24%Cr-13%Ni.
- (2) Superior crack and corrosion resistance due to moderate ferrite content.
- (3) Ideal for welding dissimilar metals (carbon steel to stainless steel).

Welding Instruction

- (1) Use Ar blend with 1~2%O₂ for high current, spray transfer welding .
- (2) Use Ar blend with 1~2%CO₂ for low current, short-circuit transfer welding.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Ni
0.021	0.76	2.35	0.012	0.010	23.88	13.76

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+1%O₂)

Tensile Strength MPa	Yield Strength MPa	Elongation %
570	410	39

Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm)		
		0.9	1.2	1.6
Ar+1~2%CO ₂	Amp	60~140	100~210	—
	Volt	15~21	17~22	—
Ar+1~2%O ₂	Amp	170~260	200~300	220~330
	Volt	24~30	24~30	24~32

Diam.	5kg Spool	15 kg Spool
0.9mm	KM3090905	KM3090915
1.2mm	KM3091205	KM3091215
1.6mm		KM3091615

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