

# BW-309LSi

## Professional Welding Wire

High quality stainless steel GMAW wire.



Specification: AWS/ASME-SFA A5.9: ER309LSi.

### Applications & Features:

BW-309LSi is a stainless steel mig welding wire. Weld metal is austenite structure with low carbon 24%Cr-13%Ni. Ideal for welding dissimilar metals (carbon steel and stainless steel).

### Characteristics:

Smooth beads, better weldability and puddle fluidity. Superior crack and corrosion resistance due to moderate ferrite content.

### Notes on Usage:

Use Argon mixed gas with 1-2% O<sub>2</sub> for high current spray transfer welding.

Use Argon mixed gas with 1-2% CO<sub>2</sub> for low current short circuit transfer welding.

### Approvals:

TUV, ABS, BV, CWB

### Part Numbers:

P/N: 2031 (0.9mm 15kg Spool)

P/N: 2032 (1.2mm 15kg Spool)



### Typical chemical composition of weld metal (wt%): (Shielding Gas: Ar+1%O<sub>2</sub>)

C	Si	Mn	P	S	Cr	Ni
0.021	0.76	2.35	0.012	0.01	23.88	13.76

### Typical mechanical properties of weld metal : (Shielding Gas Ar+1%O<sub>2</sub>)

Tensile Strength N/mm <sup>2</sup> (kgf/mm)	Yield Strength N/mm <sup>2</sup> (kgf/mm)	Elongation %
570(58.1)	410 (41.8)	39

### Size & suggested operating range: (DC+):

Operating Range		2031 (0.9mm)	2032 (1.2mm)
Ar+1-2% CO <sub>2</sub>	Amp	60-140	100-210
	Volt	15-21	17-22
Ar+1-2% O <sub>2</sub>	Amp	180-280	200-300
	Volt	24-30	24-30