

Stainless Steel MIG Wire

GM309LSi/GT309LSi

AWS A5.9 ER309LSi
JIS Z 3321 YS309LSi
ISO 14343-A-G 23 12 L Si
14343-A-W 23 12 L Si

Product Features:

- GM309LSi is a gas metal arc welding wire to be used with Ar+0.5~2%O₂ shield gas. Arc is stable, beaded appearance is beautiful and its ability to weld is satisfactory. Low carbon in the filler metal reduces the possibility of intergranular carbide precipitation and thereby, increases the resistance to intergranular corrosion. Deposited metal contains an adequate amount of ferrite and shows excellent resistance to heat cracking.
- Welding of 25% Cr- 12%Ni stainless steels, 18% Cr-8%Ni stainless steel, clad steels and dissimilar metal such as mild steels to stainless steels for petroleum, chemical engineering and textile industries.

Guideline in Usage:

- When high X-ray quality is required, stable spray transfer mode should be maintained with a low current and slow welding speed using a pulsed arc power source.
- In the welding of dissimilar metals, excessive dilution deteriorates crack and corrosion resistance. Care should be taken against the penetration of the base metal.

Shielding gas:

- Ar + 1~2% O₂ (MIG)

Typical chemical composition of wire (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.01	0.83	1.87	13.64	23.01	0.08	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-46°C) J	Hardness (HV)
468	608	36	90	90

Wire size & recommended welding parameters ; DC+

Diameter (mm)	0.9/1.0	1.2	1.6
Current range (Amp)	70~200	90~250	200~300

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