NST TIG 309 LSi

AWS: A5.9 ER 309LSi

EN ISO 14343: 2009 23 12 LSi

Tig-rod for welding of corrosion resistant material against carbon steels.

General description:

NST TIG 309LSi is a TIG-rod for welding corrosion resistant materials against carbon steel and for cladding of carbon steel.
The filler rod is used for manual welding of both pipes and plates.
Normally, Argon or Argon/Helium mix is used as the shielding gas.
Level of gas flow is dependent upon diameter and specific application.
NST TIG 309LSi gives a ductile and crack resistant weld metal.
The TIG-rods are being supplied in 1000mm lengths, colour coded in orange with zebra stripes, and with the AWS designation embossed, according to the requirements of the NORSOK standard.
"Purity" is the keyword when welding high alloyed materials. Impurities in the weld, will cause porosity.
When cladding carbon steel, the analysis of the weld metal will be equivalent of AISI 304 in the first layer.
Inter-pass temperature should not exceed 150 °C, and heat input should not exceed 2.0kJ/mm.

Welding positions:

Welding current:

DC-

Gas flow:

8-20 l/min.

Chemical composition of welding rod:

C	Si	Mn	P	S	Cu	Ni	Cr		
Max 0.03	0.65-1.0	1.0-2.5	Max 0.03	Max 0.02	Max 0.30	12.0-14.0	23.0-25.0		

Shielding gas:

Shielding gas: Ar, Ar+He.
Root gas/purge gas: Ar.

Typical mechanical properties of all-weld-metal:

Yield and Tensile Strengths				
Yield Mpa(Rp0.2)	Tensile Mpa(Rm)	Elongation %		
410	570	38		

Ferrite content:

WRC	De Long	Schaeffler	
8.7FN	12.8%	9.6%	

Packaging information:

1,6 mm x 1000mm x 5Kg
2,0 mm x 1000mm x 5Kg
2,4 mm x 1000mm x 5Kg

Colour coding: Orange with zebra stripes.

Approvals:

TÜV, DB, CE

Reference / date:

NST TIG 309LSi,
English, 06.08.2018.