

# OK Tigrod 309LSi

Bare, corrosion-resistant, chromium-nickel welding rod for welding steels with similar composition, wrought and cast steels of the 23% Cr-12% Ni types. The alloy is also used for welding buffer layers on CMn steels and for welding dissimilar joints. When using the wire for buffer layers and dissimilar joints, it is necessary to control the dilution of the weld. OK Tigrod 309LSi has good general corrosion resistance. The higher silicon content improves the welding properties such as wetting.

<b>Classifications Wire Electrode:</b>	SFA/AWS A5.9:ER309LSi, Werkstoffnummer :~1.4332, EN ISO 14343-A:W 23 12 L Si
<b>Approvals:</b>	CE EN 13479, NAKS/HAKC 2.4mm, DB 43.039.17, VdTÜV 12489

Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type:</b>	Austenitic (with approx. 8 % ferrite) 24 % Cr - 13 % Ni - Low C
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## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	475 MPa	635 MPa	32 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As welded	20 °C	150 J
As welded	0 °C	150 J
As welded	-60 °C	150 J
As welded	-110 °C	130 J

## Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Ferrite FN
0.02	1.7	0.9	13.5	23.4	0.15	0.12	9