

DESCRIPTION

Executive 309/309LSi wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 309/309LSi is the best choice for dissimilar welding of stainless to carbon or low alloy steels.

Executive 309/309LSi has a high silicon content that allows for better wetting out smoother welds with a clean final bead appearance. High silicon bare wire is ideal for its enhanced weldability.

APPLICATIONS & FEATURES

Executive 309/309LSi is used in the automotive industry, pressure piping, vessel manufacturing, cladding, and general manufacturing and fabrication.

Executive 309/309LSi has a maximum carbon level of 0.03% which enhances the resistance to intergranular corrosion.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	
0.02	23.03	13.76	0.14	1.53	0.76	0.001	0.023	0.01	
Tensile Strength:		75,000 PSI min		Elongation:		30%		Ferrite Range: 7- 11 FN (WRC-92)	
Yield Strength:		60,500 PSI min							

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short - Spray	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar
	.045"	22-23	180-210		
	.062"	23-24	200-220		
	.035"	23-25	190-260		
	.045"	25-28	250-330		
	.062"	28-31	310-350		
GTAW	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.093"	29-32	300-350	Record IND 24 or Record IN	
	.125"	29-32	400-550		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet

CLASSIFICATION

AWS/SFA 5.9, Class **ER309/309LSi**
Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.

