



HILCO HILCHROME G309LSi

MAG wires – stainless steel – special purpose

AWS A5.9: ER 309LSi

EN ISO 14343-A: G 23 12 L Si

Werkstoffnr. 1.4332

Wire type:
MAG Solid wire

Current:



Welding positions:



Shielding gas:
M12-M13

Hilchrome G309LSi is our solid wire for MAG welding corrosion resistant and heat resistant CrNi steels, dissimilar metals and buffering. Typical applications include joining high-strength steels, un- and low alloyed heat treatable steels, stainless, ferritic chromium and austenitic chrome-nickel steels, austenitic manganese steels. Hilchrome G309L Si is suitable for joining clad steels.

Base materials to be welded:

- High strength, unalloyed and alloyed heat treatable steels; stainless, ferritic chromium and austenitic CrNi steels; steels; austenitic manganese steels
- Chemically resistant weld claddings ranging from ferritic-pearlitic steels to fine grain steels, incl. high temperature fine grain steels
- Dissimilar joining

Applications:

- Power Generation
- Repair & Maintenance
- Oil & Gas Industry
- Process Industry

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	Cr	Ni
0,03	2,00	0,90	24,0	13,0

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 400	≥ 550	≥ 30	20°C ≥ 55

Note: properties under M13

Packaging and welding data:

Dia. mm.	Spool type	Weight / spool kg.
0,8	BS300	15
1,0	BS300	15
1,2	BS300	15