DATASHEET RW 309 SI – MIG wire

Description and Applications
Welding wire for analogous, heat resisting rolled, forged and cast steels as well as for heat resistant, ferritic CrSiAl steels, e.g. in annealing plants, hardening shops, steam boiler construction, petroleum industry and the ceramic industry. Austenitic weld metal with about 8 % ferrite. Preferably used for applications involving the attack of oxidizing gases. Scaling resistant up to 1000 °C.

Rodacciai denomination and approximate equivalent with other standards

	RW 309 SI
EN ISO 14343-A:2009	
EN ISO 14343-B:2009	SS 309 SI
AWS A5.9-2012	ER 309 SI
DIN Werkstoff Nr.	(1.4829)

Filler metal properties
Chemical composition (nominal) in %

	C	**Mn**	**Si**	**S**	**P**	**Cr**	**Ni**	**Mo**	**Cu**	**Co**	**N**	**Nb**	**B**
min	0,070	1,50	0,80	0,007		23,00	12,50						
max	0,110	2,00	0,95	0,015	0,025	23,70	13,00	0,40	0,30	0,20	0,065	0,050	0,002

Metal properties
The following data are typical for non-heat treated weld metal from MIG welding with M1 DIN EN ISO 14175 as shielded gas.

Expected minimum mechanical properties of all weld metal

Temperature	°C	20
Yield strength, Rp 0,2	N/mm²	450
Tensile strength, Rm	N/mm²	620
Elongation, A5	%	32
Impact energy, ISO – V	J	100

Packaging forms
Blue metallic wire baskets BS300 of 15 kg.
Plastic spools D300 of 12,5 kg for diam. 0,80 mm and of 15 kg for the other diameters.
Plastic spools D200 of 5 kg.
Drum packaging of about 150 kg for diameter 0,80 mm and of about 250 kg for the other diameters.
Diameters : 0,80 – 0,90 – 1,00 – 1,20 – 1,60 mm.