



## AMA 30-18 T

**Standards:** AWS/ASME SFA-5.9

ER 309 LSi

**Application/ Properties:** Austenitic-ferritic welding rod for TIG welding of high alloy steels to unalloyed steels. Highest operating temperature is 300 C.

### Wire Analysis:

C	Si	Cr	Mn	Ni
<0.030	0.65-1	23-25	1-2.5	12-14

**Shielding gas:** 100% Argon

### Mechanical properties of all - weld metal :

Tensile Strength (N/mm <sup>2</sup> )	0.2% Proof Stress (N/mm <sup>2</sup> )	Elongation Lo = 4d %	Impact energy (j) (J) ISO - V 25 °C
>520	>400	>30	>47

### Material:

**DIN EN standard** 1.4406 X2CrNiMoN 17 12 2 ; 1.4401 X5CrNiMo 17 12 2 ; 1.4404 X2CrNiMo17 13 2 G-X2CrNiMoN 18 10 ; 1.4311 X2CrNiN 18 10

**other Standard** ASTM/ACI A240/A312/A351 : (TP)304LN ; (TP)304L ; CF-3 ; (TP)304

**Delivery:** welding rods

weight :5 kg.

diameter : 1-4 mm.

Length: 1000mm.

**Note:** other weight & sizes are produced upon customers request.

