



MIG 24/12S

Old reference: MIG 309LSi

Classification

ISO 14343-A : G 23 12 L Si
 AWS A5.9 : ER309LSi

Material N° : 1.4332

Description & Applications

Solid wire for joining of stainless steels (309, 309L...). Well adapted for welding of dissimilar steels, carbon to stainless steels.

Main applications: For welding high temperature steels and as buffer layer before hardfacing.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe	FN
0.015	0.85	1.8	23.3	13.7	0.1	0.1	<0.02	<0.01	Rem.	~12

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
420	600	35	+20°C 130

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	100-150	22-27	Ar + 2%CO ₂ Ar + 1%O ₂ 18-20 l/min
	1.0	120-200	24-28	
	1.2	140-220	24-28	
	1.6	180-260	24-30	

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