

Satin Glide® 309LHS Stainless-Steel Welding Wire



Satin Glide® 309LHS Stainless-Steel Welding Wire is a premium filler metal that promotes excellent weldability and smooth arc characteristics.

It offers stable and controlled arc ignition and is engineered with a higher silicon content for improved wash and wetting behavior in gas shielded welding processes. This can lead to potentially higher travel speeds for a quicker job.

Manufacturing Advantages

- All metal transfer modes of GMAW
- Robotic, mechanized, or semi-automatic welding
- Single and multi-pass weldments
- Dissimilar base metal welding
- Compatible with various austenitic and ferritic stainless-steel base metals
- Lower carbon content to reduce risk of carbide precipitation and sensitization
- Higher silicon content for improved wetting of the weld puddle
- High-temperature capabilities for overlays and cladding applications

Welding Positions

All position welding is possible when using the correct shielding gas blends, welding process, and welding parameters.

Shielding Gas Blends

- Short Circuit Transfer: 90% Helium, 7-1/2% Argon, 2-1/2% CO₂
- Spray Transfer: 95-98% Argon, 2-5% CO₂
- Spray Transfer: 98-99% Argon, 1-2% O₂
- Flow rate: 35-50 CFH

Applications

- Agricultural Equipment
- Auto Body
- Automotive Exhaust
- General Fabrication
- Heavy Equipment
- Pipe Welding
- Pressure Vessels
- Railcars
- Shipbuilding
- Structures
- Trailers

Specifications

Meets or Exceeds:

- AWS A5.9/A5.9M: ER309Si, ER309LSi
- ASME SFA-A5.9: ER309Si, ER309LSi
- ASME Section III Nuclear requirements

Storage

Welding wire should be stored in a dry, enclosed environment and in its originally sealed package.

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Stainless Steel Filler Metals for Welding Dissimilar Metals

201,202, 301,302, 302B,303, 304,305,308	304L	309, 309S	310, 310S, 314	316	316L	317	317L	321, 347, 348	330	403,405, 410,414, 416,420	430,430F, 431,440A, 440B,440C	448	501, 502	505	CARBON STEEL	CR-MO STEEL
		309	309	309	309	309	309	309	309	309	309	310	309	309	309	309

Typical Wire Chemistry Percentages (as required per AWS)

ASME SFA 5.9	AWS A5.9/ AWS A5.9M	Carbon	Cr	Ni	Mn	Si	OTHER
Yes	Yes	0.07 Max	23.00/25.00	12.00/14.00	1.60/2.50	0.70/1.00	



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