TIG 309L

TIG 309L is mainly used under high dilution conditions, particularly Dissimilar welds between stainless and CMn steels. There are 3 main areas of application: Buffer layers and clad steels, Dissimilar joints and Similar metal joints.

MATERIALS TO BE WELDED

There are 3 main areas of application. Buffer layers and clad steels. Dissimilar joints and Hardenable steels

CLASSIFICATIONS

AWS	A5.9	ER309L
BS EN	12072	G 23 12 L
DIN	8556	SG X2CrNi 24 12 (1.4332)

CHEMICAL ANALYSIS

% Carbon	0.03 max.	**% Phosphorus**	0.020 max.
% Manganese	1.00 - 2.50	**% Chromium**	23.0 - 25.0
% Silicon	0.30 - 0.65	**% Nickel**	12.0 - 14.0
% Sulphur	0.020 max.	**% Ferrite**	6.0 - 12.00

TYPICAL MECHANICAL PROPERTIES ALL WELD METAL

	TIG
Tensile Strength	550 - 650 MPa
0.2% Proof Stress	420 MPa min.
Elongation on 4d	30% min.
Impact Energy 20°C	55J

Microstructure
Austenite with ferrite in the range 6-12FN.

PACKING DATA

TIG (DC-)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.60	100	12	030-570	5
2.40	100	12	030-571	5

Suggested gas for welding : Argon (TIG)

For more information contact the Afrox Customer Service Centre,
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