

Stainless solid wire

Classification

AWS A5.9 : ER309L
EN 12072 : W 23 12 L

General description

Solid wire for welding stainless steel to carbon steel
Low susceptibility to embrittlement
Minimum 18FN ferrite in weldmetal

Shielding gases (acc. EN 439)

GTAW I1 Inert gas Ar (100%)

Chemical composition (w%), typical. rod

C	Mn	Si	Cr	Ni	Mo
0.010	1.65	0.35	24	13	0.05

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)
Typical values	GTAW	I1	AW	390	600	35

Materials to be welded

Steel grades	EN 10088-1/-2	W.Nr.	ASTM/ACI	UNS
			A240/A312/A351	
Corrosion resistant	X2 CrNiN 18-10	1.4311	(TP)304LN	S30453
Cladsteel	X2 CrNi 19-11	1.4306	(TP)304L	S30403
	X4 CrNi 18-10	1.4301	CF-3 (TP)304	J92500 S30400

- Dissimilar metals (mild and low alloyed steel to stainless steel)
- Build-up welding on mild and low alloyed steel

Packaging and available sizes

Process	Unit	Diameter (mm)	1.6	2.0	2.4
GTAW	2 and 10 kg tube		X	X	X

Other sizes and packaging on request

LNT 309LHF: rev. EN 20