

ES TIG 309L

GTAW
ER309L

ESWECO
The Art of Welding

Description

Bare, corrosion-resistant, chromium-nickel welding rod for welding the 24%Cr, 13%Ni alloyed types of steel. The alloy is also used for welding buffer layers on C/Mn steels and for welding dissimilar joints. When using the wire for buffer layers and dissimilar joints, it is necessary to control the dilution of the weld.

ES TIG 309L has good general corrosion resistance. When used for joining dissimilar materials, the corrosion resistance is of secondary importance.

Current

DC (-)

Classifications

SFA/AWS A5.9	ER309L
EN 12072	W23 12 L
Werkstoffnummer	~1.4332

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.5	1.8	24.0	13.0	<0.3	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	430
Tensile strength, MPa	590
Elongation, %	40

Charpy V

Test temps, °C	Impact values, J
+20	160
-60	130
-110	90

Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0