



TIG 309L



Standards

AWS 5.9
ER 309L

EN ISO 14343-A
W 23 12 L

W. Nr.
1.4332

Description & applications

Filler metal in solid wire sticks for TIG welding of stainless steels with mild or low alloy steels, as well as barrier layer for overlays of stainless steels on such substrates. Good overall resistance to corrosion & high temperature oxidation.

Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Mo	S max	P Max	Fe
0.025	1.8	0.45	24.0	13.0	0.3	0.02	0.02	Base

Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV-196°C
620 MPa	420 MPa	36 %	46 J

Operating parameters

Shielding gas recommendations :

EN ISO 14175 I1 : 100 % Argon 6 -12 l/mn

Root : Argon, Nitrogen 3 -6 l/mn



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