

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 CMn steels and welding dissimilar joints. When using the wire for buffer layers and dissimilar joints, it is necessary to control the dilution of the weld.

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

Welding current

DC (-)

Classifications

SFA/AWS A5.9	ER309L
EN 12072	W 23 12 L
Werkstoffnummer	~1.4332

Wire 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

Approvals

VdTÜV

Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.2	1000	5.0
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0
4.0	1000	5.0