



MIGINOX 309L

GMAW STAINLESS STEEL

AWS A/SFA 5.9 ER309L

CLASSIFICATION:

EN ISO 14343-A

G 23 12 L

IS 5856

ES 24.13 L

KEY FEATURES:

- An extra low carbon 23Cr/12Ni type stainless steel wire
- Excellent corrosion and oxidation resistance up to 1100°C
- High ferrite content ensures highest cracking resistance
- Radiographic quality weld

APPROVALS: Class VI/CE

TYPICAL APPLICATIONS:

- Welding of AISI 309, 309L type steels
- Dissimilar joints between stainless steels and low alloy or carbon steels
- Buffer layer on low alloy and carbon steels
- Joining corrosion resistant clad steels



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Ni
0.027	1.9	0.4	23.5	12.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	590	40

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		All Positions
0.8	12.5	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	
1.2	12.5		
1.6	12.5		

Shielding Gas	Gas Flow Rate, LPM
98Ar/2O ₂ or Ar/1-5CO ₂	15-22