



Stainless Steel Solid Wire

MIG/TIG Welding

AWS A5.9: ER309L
ISO14343-A-2009 23 12 L

SW-309L

DESCRIPTION & APPLICATION

MIG/TIG Filler wire for the joining and overlay of Stainless Steels of similar composition, such as AISI 309 castings. Low carbon content minimises Carbide precipitation. May also be used as a dissimilar consumable and for joining 3Cr12.

BASE MATERIALS

All 300 series Austenitic Stainless Steel, Overlay of Mild Steel (Cladding)
Joining of Austenitic Manganese Steels (Hadfields), 3Cr12 and for dissimilar applications.

MECHANICAL PROPERTIES

~600 UTS n/mm	>380 YIELD 0.2%	>30 ELONG A5%	>40 CV (J) -196°C
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METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo	S	P	Fe
0.02	0.6	1.9	23.5	12.5	0.05	0.002	0.02	BAL

PACKAGING

15kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

0.8, 1.0, 1.2mm (MIG)
1.6, 2.4, 3.2mm (TIG)

WELDING INSTRUCTIONS

Shielding gas 5% or 20% CO₂ in Argon, or 2% Argon-Ox (MIG). 100% Argon (TIG). Do not allow the base material to overheat, maintain interpass temperature below 150°C.

For more details on welding of Stainless steel, please see our Information Sheets.
Visit: www.westbrookwelding.co.uk/downloads