



AWS	A5.9 ER309L
EN	EN12072 G 23 12 L
JIS	Z3321 Y309L

Characteristics:

It is the low carbon content designed to prevent intergranular corrosion. It is used to join similar 309L alloys or join 300 series stainless steels to carbon or low alloy steels.

Applications:

It is used for oil and gas refineries, include welding of AISI 309 in chemical and welding of dissimilar base metals of stainless and carbon steels.

Notes on Usage:

1. For TIG process, use DC(-) current , Argo Shield and Tungsten Electrode.
2. For MIG process, use Spray Transfer or Short Circuit Transfer mode.
3. 98%Argon – 2%O₂ shielding gas is recommended in MIG process.

Typical chemical composition of weld metal (wt%)

C	Cr	Ni	Mn	Si
0.024	23.80	12.80	1.98	0.39

Typical mechanical properties of weld metal

TS N/mm ²	EL %
590	40

Sizes available

MIG Solid Wire(mm)	0.8	0.9	1.0	1.2
TIG Rods(mm)	1.6	2.0	2.4	3.2