

Classification

AWS A 5.9 : ER 309 L EN 12072 : W 23 12 L

Typical weld metal chemical composition (%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.03 max	1.50-2.20	0.30-0.65	23.00-25.00	12.00-14.00	0.75 max.	0.75 max.	0.03 max.	0.03 max.

All weld metal mechanical properties (typical)

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact energy ISO-V(J) 20°C
≥ 350	≥ 520	≥ 30	≥ 47

Description

ITR 309L is a stainless TIG rod conforming to ER 309L for welding austenitic stainless steels such as AISI 309. It is also used to weld dissimilar steels and for buffer layers and buttering 18 Cr/ 8 Ni steels. Excellent oxidation and corrosion resistance in continuous service up to 1100°C. Ferrite content is 15% approx.

Materials to be welded

A312 TP309S; carbon steel to stainless steels joint.

Current conditions

DC (-)

Storage

Keep dry and avoid condensation

Packing data

Size (mm) DxL	0.80 x 1000	0.90 x 1000	1.00 x 1000	1.20 x 1000	1.60 x 1000	2.00 x 1000	2.40 x 1000	3.20 x 1000	4.00 x 1000
Net wt. per tube (kg)	5	5	5	5	5	5	5	5	5
Net wt. per box (kg)	20	20	20	20	20	20	20	20	20

Welding positions

