

PRODUCT NAME

SW 309L

CONFORMANCES

- **AWS** : A5.22/ASME SFA5.22 E309LT1-1/-4
- **JIS** : Z3323 TS309L-FB1
- **EN** : ISO 17633-A T 23 12L P M/C 2

FEATURES

- welded with 100%CO₂ or Ar+20-25% CO₂
- Current: DC+
- Superior corrosion and heat resistance
- High efficiency
- Suitable for all welding positions.

APPLICATIONS

- 23.5%Cr-13%Ni stainless steel
- Dissimilar welds between carbon, low alloy steels to stainless steels
- Buffer layer welding for cladding, overlays

CHEMICAL COMPOSITION

	C	Mn	Si	P	Cr	S	Ni	Mo
100% CO ₂	0.03	1.20	0.75	0.02	22.8	0.01	12.3	0.05
Ar+20-25% CO ₂	0.03	1.30	0.80	0.02	23	0.01	12.5	0.05

MECHANICAL PROPERTIES

	TS MPa(Lbs/in ²)	EL (%)	Temp °C(°F)	CVN-impact value J(ft.lbs)	Ferrite number
100% CO ₂	560(81,300)	40	-20(-4)	50(37)	16-19
Ar+20-25% CO ₂	580(81,200)	39	-20(-4)	45(33)	16-19

DIAMETER/PACKAGING

Diameter Mm (in)	Spool	Pac
1.2(0.045)	5Kg	-
	12.5Kg	-
	15Kg	
1.4(0.052)	5Kg	
	12.5Kg	
	15Kg	