

## 309S92

TIG (GTAW)

## 309L SOLID WIRE TIG

## PRODUCT DESCRIPTION

Solid wire for TIG welding.

## CLASSIFICATIONS

AWS A5.9M	ER309L
ISO 14343-A	23 12 L
ISO 14343-B	SS309L
APPROVALS	TÜV

## ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

## CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	--	1.0	0.30	--	--	23.0	12.0	--	--	8
Max.	0.03	2.5	0.65	0.020	0.030	25.0	14.0	0.3	0.3	20
Typical	0.015	1.7	0.5	0.005	0.015	23.5	13	0.1	0.15	12

## ALL-WELD MECHANICAL PROPERTIES

As welded	Typical
Tensile strength [MPa]	590
0.2% proof strength [MPa]	450
Elongation [%] 4d	43
5d	41
Reduction of area [%]	55
Impact ISO-V(J) +20°C	>200
-20°C	--
-75°C	>150
Hardness cap/mid HV	205/225

## TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon*	DC-	2.4	100A, 12V

\* Also required as a purge for root runs.

## PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	5	PE TUBE	T309S92-16
2.0	5	PE TUBE	T309S92-20
2.4	5	PE TUBE	T309S92-24
3.2	5	PE TUBE	T309S92-32