

RASI ER 309L

TIG / MIG

23Cr/12Ni TYPE STAINLESS STEEL SOLID WIRE

MADE IN INDIA

CHARACTERISTICS

RASI ER 309L is a corrosion resisting chromium-nickel welding rod for welding of similar steels of 24% Cr, 13% Ni types. The alloy is also used for welding of buffer layers on CMn steels and welding of dissimilar joints. When using the wire for buffer layers and dissimilar joints it is necessary to control the dilution of the weld. OK Tigrod 309L has a good general corrosion resistance. When used for joining dissimilar materials the corrosion resistance is of secondary importance.

KEY FEATURES

- An extra low carbon 23Cr/12Ni type stainless steel wire
- Excellent corrosion and oxidation resistance upto 1100°C
- High ferrite content ensures highest cracking resistance
- Radiographic quality welds

CLASSIFICATIONS

SFA/AWS A5.9, ER309L

TYPICAL APPLICATIONS

- Welding of AISI 309, 309L type steels
- Dissimilar joints between stainless steels and low alloy or carbon steels
- Buffer layer on low alloy and carbon steels
- Joining corrosion resistant clad steels

WELDING POLARITY

GMAW: DCEP
GTAW: DCEN

Chemical Composition of W/led Metal (wt %)

	C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
Typical Results	0.03 max	1.0 - 2.50	0.3-0.65	0.030 Max	0.025 Max	23 - 25	12 - 14	0.75 max	---

All Weld Metal Mechanical Properties :-

	UTS (mpa)	YS (mpa)	Elongation %	CVN impact at -20C
Typical Results	520 min	---	30 min.	---

Packing Details :-

	0.80mm	1.00mm	1.20mm	1.60mm	2.0mm	2.40mm	3.2mm	4.00mm
TIG	---	5 kg	5 kg	5 kg	5 kg	5 kg	5 kg	5 kg
MIG	12.5 kg	12.5 kg	12.5 kg	12.5 kg	---	---	---	---

*FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com

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