

SA 309L

CATEGORY SAW Arc Submerged

TYPE Solid drawn stainless steel welding wire for SAW welding

APPLICATIONS Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels.

PROPERTIES High mechanical properties and very good weldability due to a increased silicon content, suitable for operating temperatures up to 300°C.

CLASSIFICATION

AWS	A 5.9: ER 309L
EN ISO	14343-A: S 23 12 L
DIN: W.Nr.	1.4332

SUITABLE FOR Buffer layers before hard facing, dissimilar joints between ferritic and austenitic steels and or difficult to weld steels such as: 42CrMo4, C45, 42MnV7, tool steels. High temperature steels such as: 22NiMoCr4-7, 20MnMoNi5-5 and GS-18NiMoCr3-7

APPROVALS CE approved

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo
<0.3	1.0-2.5	0.30-0.65	23-25	12-14	<0.3

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				+20°C	-40°C	-60°C	
AW	>390	>590	>30	>80			

AW: as welded

REDRYING TEMPERATURE not required