



TIG 24/12

Old reference: TIG 309L

Classification

ISO 14343-A : W 23 12 L
AWS A5.9 : ER309L

Material.N° : 1.4332

Description & Applications

Solid rod for TIG welding of stainless steels (309, 309L...). Well adapted for welding of dissimilar steels. Its high ferrite content allows for greater dilution without risk of cracking. Also suitable for welding high temperature steels and as buffer layer before hardfacing.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.015	0.4	1.8	23.2	13.8	0.1	0.08	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
420	620	35	+20°C	140
			-60°C	70

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

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