Key Facts

- High quality TIG rod
- Used to weld 23%Cr, 12%Ni stainless steel
- Excellent resistance to cracking

Description

The deposited metal contains an abundant amount of ferrite and shows good resistance to heat cracking.

Recommended Shielding Gas

Ar or Ar CO_2 mix

Classification, Approvals & Conformances

AWS A5.9 ER309
JIS Z3321 Y 309
DIN 8556 SG X2 CrNi 24 12

Welding Positions

All positions

Applications

For welding type 309, also for 304 clad stainless steel, stainless to mild steel and stainless steel overlay work.

- Welding dissimilar materials
- Buffer layers prior to hard facing and overlays
- Joining of wrought or cast steels

Typical Analysis/Composition

Mn - Manganese	Ni - Nickel	Mo - Molybdenum	S - Sulphur
1.0 – 2.5	12.0 – 14.0	< 0.75	< 0.03
Cr - Chromium	**C – Carbon**	**Si - Silicon**	**P - Phosphorus**
23.0 – 25.0	< 0.12	0.3 – 0.65	< 0.03
Cu - Copper			
< 0.75			

Typical Weld Mechanical Properties

0.2% Proof Stress:	400 MPa
Tensile Strength:	590 MPa
Elongation:	36%

Packaging & Ordering Information

Size	Weight	Part Number
1.6mm	1kg	300054H
1.6mm	5kg	300054
2.4mm	1kg	300055H
2.4mm	5kg	300055

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.