

RONOX-309L

STAINLESS STEEL CONTINUOUS & CUT LENGTH
SOLID WELDING WIRE FOR MIG/TIG WELDING

BASIC ALLOY: FE, CR, NI
AWS/SFA-5.9: ER309L
EN ISO 14343-A 23 12 L

KEY FEATURES:

ER309L is austenitic Stainless steel welding wire, the weld metal contains ferrite and resistance to crack is extremely good. Due to its high level of alloy, it has excellent resistance to heat.

APPLICATIONS

- ER 309L welding wire of 22%Cr-12%Ni steel for joining ferrite to austenite stainless steel for services temperature up to 300°C. Heat resistance cast steel clad side of 18% Cr-8% Ni clad steel and stainless steel to Cr-Mo steel or carbon steel

SHEILDING GAS:

- welding with 100% Ar gas Or Ar+2%O₂ gas.

CHEMICAL COMPOSITION:

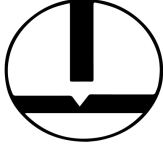
C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.030 max.	1.00-2.50	0.30-0.65	0.030 Max	0.030 Max	12.00-14.0	23.00-25.00	0.75 max	0.75 Max

MECHANICAL PROPERTIES:

UTS (N/mm)	Proof strength (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @	FERRITE Qty.(FN)
540-660	400-490	30-40	+20C : 50-80 J	10-14

WELDING POSITION

1G/1F



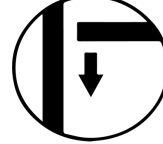
2G/2F



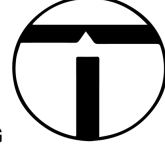
3G UP



3G DOWN



4G



DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR MIG WELDING)

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min	Spool packing 12.5 kg	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	70-220	16-24	10-20	✓	✓	X
1.20	0.047	150-300	24-34	15-25	✓	✓	✓
1.60	1/16"	150-350	28-36	15-30	✓	✓	✓

DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR TIG WELDING)

Size (mm)	Size (inch)	Length (mm)	Length (Inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	40-80	10-16	✓	✓
2.0	5/ 64"	1000	36"	50-100	12-18	✓	✓
2.4/ 2.5	3/ 32"	1000	36"	60-120	14-20	✓	✓
3.2	1/ 8"	1000	36"	100-150	16-24	✓	✓
4.0	5/ 32	1000	36"	140-200	18-28	✓	✓