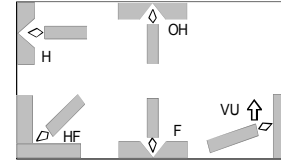


Gas Tungsten Arc Welding

TG-S309L
FAMILIARC
Filler Rods and Wires for 309L Stainless Steel
Classification: ASME / AWS A5.9 ER309L
 JIS Z3321 Y309L

Features : •Suitable for dissimilar-metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals

Shielding Gas : Ar

Welding Positions:

Chemical composition of rod and wire (%) as per AWS

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Example	0.016	0.41	1.84	0.019	0.002	13.68	23.28	0.03	0.04
Guaranty	≤0.030	0.30~ 0.65	1.00~ 2.50	≤0.030	≤0.030	12.00~ 14.00	23.00~ 25.00	≤0.75	≤0.75

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	410	570	38	0°C: 110

Polarity

Example	AC
Guaranty	AC, DC-EP

Packages

Dia. (mm)	Length (mm)	Weight per tube (kg)	Weight per piece(g)
1.2	1000	5	9
1.6	1000	5	16
2.0	1000	5	25
2.4	1000	5	35
3.2	1000	5	63