



OK Tigrod 309L

GTAW

Bare, corrosion-resistant, chromium-nickel welding rod for welding the 24%Cr, 13%Ni alloyed types of steel. The alloy is also used for welding buffer layers on CMn steels and for welding dissimilar joints. When using the wire for buffer layers and dissimilar joints, it is necessary to control the dilution of the weld. OK Tigrod 309L has good general corrosion resistance. When used for joining dissimilar materials, the corrosion resistance is of secondary importance.

Welding Current

DC (-)

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Per Pack (kg)	Pallet Weight (kg)
165312R150	1.2	5	840
165316R150	1.6	5	840
165320R150	2.0	5	840
165324R150	2.4	5	840
165332R150	3.2	5	840
165340R150	4.0	5	840

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
<u>SFA/AWS A5.9</u> ER309L <u>EN 12072</u> W 23 12 L <u>Werstoffnummer</u> ~1.4332	VdTüV 10021	C <0.03 Si 0.5 Mn 1.8 Cr 24.0 Ni 13.0 Mo <0.3 Cu <0.3	<u>Yield Stress, Mpa</u> 430 <u>Tensile Strength, Mpa</u> 590 <u>Elongation, %</u> 40 <u>Charpy V</u> Test Temps, °C Impact Values, J +20 160 -60 130 -110 90

