

## RAAJMIG ER 309L

### Stainless steel continuous & cut length solid welding wire for MIG/TIG welding

**CLASSIFICATION** : AWS/SFA-5.9: ER309L, BS 23.12.L  
DIN 8556: WK. 1.4332

**CHARACTERISTICS** : 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.

**APPLICATION** : 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.

**SHIELDING GAS** : welding with 100% Ar gas Or Ar+2%O<sub>2</sub> gas.

#### CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Ni
0.030 max.	1.00-2.50	0.30-0.65	0.030 Max	0.030 Max	12.00-14.00
Cr	Mo	Cu			
23.00-25.00	0.75 max.	0.75 Max			

#### ALL WELD MECHANICAL PROPERTIES (UNDER Ar GAS SHIELD)

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

#### DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIGER309L)

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 (RAAJTIGER309L)

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	√	√

**Raajratna** offer a wide range of Stainless steel welding wires for MIG/TIG/SA welding.

And also available RAAJMIGER309LSi version for MIG welding process

Customer packing on request.