

# 309L FILLER METAL(GTAW)

FILLER METAL ELECTRODE WITH STAINLESS STEEL 309L ALLOY (25% CHROMIUM and 12 % NICKEL) TO BE USED IN GTAW PROCESS .

CLASSIFICATION A.W.S: ER-309L

IDENTIFICATION: BUNDLE

**APPLICATIONS:** 309L is a stainless steel electrode. It is used in acetic acid pipes, bulk cargo tanks, oil refineries, acid fume extractors, milk industry equipment, sterilizing units, ovens, heat exchangers, caustic soda tanks and heat treatment ovens

**CHARACTERISTICS AND PROCEDURE:** Its high chromium and nickel content provides resistance to corrosion and decreases the risk of granular corrosion, even after prolonged exposure to high temperatures. It is recommended for GTAW (TIG) process in which Argon or a gas mixture is used as the shielding gas. It is supplied in 5.0 Kg. bundles with a length of 36 inches. Diameters are either 1/16", 3/32", 1/8" or 5/32". This electrode is also manufactured as a microwire supplied in 13.620 Kg. reels with diameters of either 0.035" or 0.045" to be used in GMAW process.

TENSILE RESISTANCE:	5,835 KG./CM2 (83,000 PSI)
ELONGATION	33%
CURRENT:	TIG PROCESS

FILLER METAL CHEMICAL ANALYSIS %				
C	Mn	Si	Cr	Ni
0.02	0.71	0.79	25.50	13.1