



Cromasaw 309L

SAW-Submerged arc welding
Stainless Steel

Date: 2004-04-15
Revision: 5

Description:

Cromasaw 309L is a submerged arc wire for use in combination with Cromaflex 300B, depositing a 23% Cr / 13% Ni austenitic stainless steel weld metal with a ferrite content of about FN 10.

APPLICATIONS:

- Buffer layer on mild steel and low alloy steels prior to overlaying with Cromasaw 308L or 316L.
- Welding of similar composition 309 type austenitic stainless steels.
- Welding of low-restraint, light-medium section moderate dilution dissimilar joints between stainless and mild or low alloy steels.

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	1,6			22,0	11,0
Typical	0,015	0,4	1,8	<0,015	<0,015	23,5	13,5
Max	0,03	0,65	2,5	0,025	0,025	25,0	14,0

Ferrite content:

FN 13-18

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,015	0,6	1,4	<0,015	<0,01	23,0	13,3
Max							

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 320 MPa	420 MPa
Tensile Strength, Rm:	≥ 520 MPa	580 MPa
Elongation, A5	≥ 30%	38%
Impact energy, CV:		20°C • 100 J

Product data

Product code	Diam.mm	Current A	Voltage V
9804-5024	2,4	300-500	26-30
9804-5032	3,2	300-500	28-30
9804-5040	4,0	300-500	28-32
		300-500	

Classification:

EN 12072	S 23.12.L
AWS A5.9	ER 309L
BS 5465	309 S92
DIN 8556	X2 CrNi 24.12
Werkstoff no.	1.4332

Approvals: