



UP 309L

Classification

AWS A5.9 : ER309L

ISO 14343-A : S 23 12 L

Description & Applications

Low carbon solid wire for SAW of stainless steels with similar chemical composition like 309 and 309L. Well adapted for welding of dissimilar steels like low alloy steels, ferritic stainless steel like 430, martensitic stainless steel like 410. Also suitable for welding high temperature steels and as buffer layer before hardfacing.

Its high ferrite content allows for greater dilution without risk of cracking.

Main applications: Boiler making, civil engineering, maintenance and repairs...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Co	N	Fe
Min	0.30	1.0	23.0	12.0									
Max	0.03	0.65	2.5	25.0	14.0	0.5	0.5	-	0.03	0.02	-	-	Rem.
Type	0.015	0.40	1.8	23.2	13.8	0.10	0.08	0.01	0.02	0.01	0.06	0.08	Rem.

Delong ferrite: ~12%

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters				Flux
		Current (A)	Voltage (V)	Stick out (mm)	Speed (cm/min)	
SAW =+	2.4 3.2	200 - 400 300 - 500	25 - 30 28 - 32	18 - 25 20 - 30	40 - 60 40 - 60	WP380 WP380M