

BW-309L

Professional Welding Wire

Stainless Steel Tig Filler Rod (GTAW)



Specification: AWS/ASME-SFA A5.9: ER309L

Applications & Features:

BW-309L stainless steel is a high-quality low carbon rod for the welding of high alloy 309 or 309L type stainless steels.

Suitable for welding stainless steel to carbon steel or use for welding similar alloys in wrought or cast form.

Weld metal is austenite structure with low carbon 24%Cr-13%Ni.

Contains adequate amount of ferrite and with good resistance to heat cracking.

Approvals:

ABS, CWB

Part Numbers:

P/N: 3022 - 1.6mm x 1000mm

P/N: 3024 - 2.4mm x 1000mm

Pack Sizes:

5.0kg Sealable Tube



Chemical composition of solid wire (wt%)

C	Si	Mn	P	S	Cr	Ni
0.022	0.39	1.94	0.009	0.011	23.84	12.92

Typical Mechanical Properties

Tensile Strength MPa	Yield Strength MPa	Elongation %
580	410	41

Suggested Operating Range

Size mm	Current Amps	Gas Flow L/min	Shielding Gas
1.6	75-100	25	100% Argon
2.4	150-200	25	100% Argon