

Exaton 309/309L HF

309/309L HF welding wire is used for MIG/MAG welding. It is particularly suitable for overlay welding and joining dissimilar steels, for example austenitic stainless steels to low alloyed or non alloyed steels. It has excellent resistance to hot cracking due to its enhanced ferrite content.

Classifications Wire Electrode	SFA/AWS A5.9 : ER309L EN ISO 14343-A : G 23 12 L
Approvals	CE EN 13479 VdTUV 02103

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 14 % ferrite) 24 % Cr - 13 % Ni - Low C
Shielding Gas	M12, M13 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	110 J (81 ft-lb)
As Welded	-60 °C (-76 °F)	85 J (63 ft-lb)
As Welded	-196 °C (-321 °F)	35 J (26 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.02	1.7	0.3	0.001	0.013	13.4	23.6	0.02	0.03	0.01

Typical Weld Metal Analysis %

N	Nb	Co	FN deLong	FN WRC
0.07	0.01	0.03	12	11

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.01	1.8	0.4	0.001	0.011	13.4	23.5	0.04	0.05	0.03

Typical Wire Composition %

N	Nb	Ti	Co	FN deLong	FN WRC
0.05	0.03	0.004	0.03	14	13

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)