

Exaton 309L HF

309L HF welding wire is used for TIG, plasma-arc, MIG and submerged-arc 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. It is used for TIG-welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER309L EN ISO 14343-A : W 23 12 L
Approvals	CE EN 13479 VdTUV 00936

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
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Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	175 J (130 ft-lb)
As Welded	-40 °C (-40 °F)	160 J (118 ft-lb)
As Welded	-60 °C (-76 °F)	150 J (111 ft-lb)

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.015	1.8	0.3	<=0.015	<=0.015	13	24	<=0.3	<=0.10	<0.06

Typical Wire Composition %

Co
<=0.05