

# T-309L

For austenite stainless steel (Low carbon, Dissimilar steels)

## Classifications

EN ISO 14343-B:2009	: SS 309L
AWS A5.9-2012	: ER309L
JIS Z 3321:2013	: YS309L
KS D 3696:2006	: STSY309L

## Approvals – I1 (100% Ar)

BV	: T-309L
DNV	: NV 309L
LR	: SS/CMn m
KR	: RY309LG(I)
RS	: A-9sp

## Description

- TIG welding of 22%Cr-12%Ni STS and dissimilar steels such as 304L to mild steels or low alloy steels
- Various applications of petrochemical and fiber industrial apparatus

## Polarity & shielding gas

- DCEN (DC-)
- Ar: 100% Ar (15 – 25 l/min)

## Typical chemical composition of all-weld metal (%)

C	Si	Mn	Ni	Cr
0.01	0.45	1.64	13.78	23.09

## Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)	
	(MPa)	(MPa)	(%)	0 °C	-196 °C
AWS A5.9		Min. 520	Min. 30		
EN ISO 14343	Min. 320	Min. 510	Min. 25		
Example	445	568	42	130	52