

Exaton 309/309L HF

309/309L HF welding wire 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 Submerged Arc Welding.

Specifications

Classifications	EN ISO 14343-A : S 23 12 L SFA/AWS A5.9 : ER309L
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 03771

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

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	23.8	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