

OK Tigrod 309L

Bare corrosion resisting chromium-nickel welding rod for welding of similar steels of 24% Cr, 13% Ni types. The alloy is also used for welding of buffer layers on CMn steels and welding of dissimilar joints. When using the wire for buffer layers and dissimilar joints it is necessary to control the dilution of the weld. OK Tigrod 309L has a good general corrosion resistance. When used for joining dissimilar materials the corrosion resistance is of secondary importance.

Specifications

Classifications	EN ISO 14343-A : W 23 12 L SFA/AWS A5.9 : ER309L
Approvals	CE : EN 13479 CWB : ER309L UKCA : EN 13479 VdTÜV : 10021

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

Alloy Type	Austenitic (with approx. 10 % ferrite) 24 % Cr - 13 % Ni - Low C
Shielding Gas	I1 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	430 MPa (62 ksi)	590 MPa (86 ksi)	32 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
As Welded	20 °C (68 °F)	160 J (118 ft-lb)
As Welded	-60 °C (-76 °F)	130 J (96 ft-lb)
As Welded	-110 °C (-166 °F)	90 J (67 ft-lb)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	N	FN WRC-92
0.02	1.8	0.4	13.4	23.2	0.10	0.1	0.05	10

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.015	1.7	0.4	0.015	0.020	13.0	24.0	0.1	0.1	0.08

Typical Weld Metal Analysis %

FN WRC-92
12