



WB309LM M.I.G. WELDING WIRE

Classifications AWS A5.9-81 : ER309LSi BSEN12072-00 : G23 12L Si

Product Description 309L stainless steel, solid MIG wire.

Applications WB309LM is used mainly for welding stainless steels and wrought and cast alloys to carbon steels such as 304 clad steels. This is known as a transition weld used largely for pressure vessel fabrications. For cladding it deposits a 308 type deposit on carbon steel and can be followed by 307 weld metal. 8-20FN range.

Wire Composition (Weight %)		C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.		-	1.0	0.60	-	-	23.0	12.0	-	-
max.		0.03	2.5	1.00	0.03	0.03	25.0	14.0	0.5	0.50

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm ²	510 min.
	Yield Stress/0.2% Proof Stress	N/mm ²	320 min.
	Elongation on 5D	%	25 min.
	Impact Energy CV @ as-welded	Joules	-

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
min.		-	80	120	160	180	-	-
Current Range (Amps)	max.	-	180	240	260	300	-	-
min.		-	17	17	18	20	-	-
Volt Range (Volts)	max.	-	20	22	26	29	-	-

Packaging Information

Kg Per Reel - 0.7/5/15 0.7/5/15 15 15 - -

Storage **Storage**
It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.

Gases	Gas MIG CO ₂ and Argon/CO ₂ mixture	Gas TIG Argon
	Flow Rate 12-16 l/min	Flow Rate 8-12 l/min

Current Conditions DC+ and Welding Positions

