



WB309LT T.I.G. WELDING WIRE

Classifications

AWS A5.9-81 : ER309L

BSEN12072-00 : G23 12L

Product Description

309L stainless steel, solid TIG wire.

Applications

WB309LT 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	0.30	-	-	23.0	12.0	-	-
max.	0.03	2.5	0.65	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)

min.	0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
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Current Range (Amps)

max.	-	-	-	-	80	80	80
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Volt Range (Volts)

min.	-	-	-	-	-	-	-
max.	-	-	-	-	-	-	-

Packaging Information

Kg Per Tube

-	-	-	-	5	5	5
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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

Pure Argon

Flow Rate

7-10 l/min

Current Conditions DC- and Welding Positions

