



# WB309LT TIG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.9:</b> ER309L <b>BS EN ISO 14343-A:</b> W 23 12 L									
<b>Product Description</b>	309L stainless steel, solid TIG wire.									
<b>Applications</b>	WB309LT-SC 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.									
<b>Wire Composition (Wt. %)</b>		C	Mn	Si	S	P	Cr	Ni	Mo	Cu
<b>min.</b>		-	1.0	0.30	-	-	23.0	12.0	-	-
<b>max.</b>		0.03	2.5	0.65	0.03	0.03	25.0	14.0	0.5	0.50
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>			510 min.				
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>			320 min.				
	Elongation on 5D		%			25 min.				
	Impact Energy CV @		Joules			-				
	As welded									

<b>Wire Dia. (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	-	-	80	80	80
	<b>max.</b>	-	-	-	-	120	120	120
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	-	-	-	-	-
	<b>max.</b>	-	-	-	-	-	-	-
<b>Packaging Information</b>								
<b>Kg Per Tube</b>		-	-	-	-	5	5	5
<b>Storage</b>	<b>Storage</b> 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%.							
<b>Gases</b>	<b>Gas</b> Pure Argon  <b>Flow Rate</b> 12-14 l/min							

## Current Conditions DC- and Welding Positions

