WB309L MIG WELDING WIRE

Classifications	**AWS A5.9:** ER309L **BS EN ISO 14343-A:** G 23 12 L
Product Description	309L stainless steel, solid MIG wire.
Applications	WB309L 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 (Wt. %)

	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	0.02	0.03	25.0	14.0	0.50	0.50

Typical All-Weld Metal Mechanical Properties

Ultimate Tensile Strength	N/mm²	550 min.
Yield Stress/0.2% Proof Stress	N/mm²	320 min.
Elongation on 5D	%	30 min.
Impact Energy CV @ As welded	Joules	-

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	**min.**	-	80	120	160	180	-	-
	max.	-	180	240	260	300	-	-
Volt Range (Volts)	**min.**	-	17	17	18	20	-	-
	max.	-	20	22	26	29	-	-
Packaging Information **Kg Per Reel**		-	0.7/15	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
Argon + 2%O_2 or Argon + 2-3%CO_2

Flow Rate
15-20 L/min

Current Conditions DC+ and Welding Positions