

## TECHNICAL DATASHEET - WELDING CONSUMABLE

<b>AWS Code:</b>	ER309L
<b>Product Code:</b>	RW 309L
<b>Werkstoff No.:</b>	1.4332
<b>MIG Certification:</b>	CWB
<b>TIG Certification:</b>	CWB

### EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
23 12 L	ER309L	SS309L	ER309L

### DESCRIPTION AND APPLICATIONS

RW 309L / RW 309SI / RW 309LSI / RW 309LMO / RW309H is a 309-series stainless welding wire class for joining stainless steels to carbon steels and other dissimilar materials. RW 309L supports corrosion resistance with low carbon, RW 309LSI adds improved fluidity, penetration and bead appearance. RW 309SI is suitable for heat-resistant steels, including CrSiAl grades, and oxidizing gas environments with about 8% ferrite in the weld metal. RW 309LMO adds Mo for improved pitting resistance in chloride environments, RW309H is used where high-temperature performance is required.

### TYPICAL CHEMICAL COMPOSITION (%)

	Min.	Max.
<b>C</b>	-	0,03
<b>Mn</b>	1,00	2,50
<b>Si</b>	0,30	0,65
<b>S</b>	-	0,020
<b>P</b>	-	0,030
<b>Cr</b>	23,0	25,0
<b>Ni</b>	12,0	14,0
<b>Mo</b>	-	0,30
<b>Cu</b>	-	0,30
<b>N</b>	-	-
<b>Nb</b>	-	-
<b>Ti</b>	-	-

### DIAMETER

<b>MIG sizes</b>	0,8   0,9   1,0   1,14   1,2   1,6
<b>TIG sizes</b>	0,8   0,9   1,0   1,2   1,6   2,0   2,4   3,2   4,0
<b>SAW sizes</b>	1,6   2,0   2,4   3,2   4,0

### PACKAGING

<b>MIG</b>	Blue Metallic Wire Basket BS300: 15 Kg. Plastic Spool D300: 15 Kg. Plastic Spool D200: 5 Kg. Wooden/Metallic Bulk Spool: 250 Kg. Drum: 250-400 Kg.
<b>TIG</b>	Carton Boxes/Tubes: 5 Kg. (1000 mm Rod Length)
<b>SAW</b>	Metallic Wire Basket K415 Wooden/Metallic Bulk Spool: 250 Kg. Drum: 300 Kg.

Note: Safety Data Sheet is available on request.

## TECHNICAL DATASHEET - WELDING CONSUMABLE

<b>AWS Code:</b>	ER309Si
<b>Product Code:</b>	RW 309SI
<b>Werkstoff No.:</b>	(1.4829)
<b>MIG Certification:</b>	CE
<b>TIG Certification:</b>	CE

### EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
-	ER309Si	SS309Si	ER309Si

### DESCRIPTION AND APPLICATIONS

RW 309L / RW 309SI / RW 309LSI / RW 309LMO / RW309H is a 309-series stainless welding wire class for joining stainless steels to carbon steels and other dissimilar materials. RW 309L supports corrosion resistance with low carbon, RW 309LSI adds improved fluidity, penetration and bead appearance. RW 309SI is suitable for heat-resistant steels, including CrSiAl grades, and oxidizing gas environments with about 8% ferrite in the weld metal. RW 309LMO adds Mo for improved pitting resistance in chloride environments, RW309H is used where high-temperature performance is required.

### TYPICAL CHEMICAL COMPOSITION (%)

	Min.	Max.
<b>C</b>	-	0,12
<b>Mn</b>	1,00	2,50
<b>Si</b>	0,65	1,00
<b>S</b>	-	0,030
<b>P</b>	-	0,030
<b>Cr</b>	23,0	25,0
<b>Ni</b>	12,0	14,0
<b>Mo</b>	-	0,75
<b>Cu</b>	-	0,75
<b>N</b>	-	-
<b>Nb</b>	-	-
<b>Ti</b>	-	-

### DIAMETER

<b>MIG sizes</b>	0,8   0,9   1,0   1,14   1,2   1,6
<b>TIG sizes</b>	0,8   0,9   1,0   1,2   1,6   2,0   2,4   3,2   4,0
<b>SAW sizes</b>	1,6   2,0   2,4   3,2   4,0

### PACKAGING

<b>MIG</b>	Blue Metallic Wire Basket BS300: 15 Kg. Plastic Spool D300: 15 Kg. Plastic Spool D200: 5 Kg. Wooden/Metallic Bulk Spool: 250 Kg. Drum: 250-400 Kg.
<b>TIG</b>	Carton Boxes/Tubes: 5 Kg. (1000 mm Rod Length)
<b>SAW</b>	Metallic Wire Basket K415 Wooden/Metallic Bulk Spool: 250 Kg. Drum: 300 Kg.

Note: Safety Data Sheet is available on request.

## TECHNICAL DATASHEET - WELDING CONSUMABLE

<b>AWS Code:</b>	ER309LSi
<b>Product Code:</b>	RW 309LSI
<b>Werkstoff No.:</b>	1.4332
<b>MIG Certification:</b>	TUV (0,8-1,6 mm) - CE - DB - CWB
<b>TIG Certification:</b>	CWB

### EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
23 12 L Si	ER309LSi	SS309LSi	ER309LSi

### DESCRIPTION AND APPLICATIONS

RW 309L / RW 309SI / RW 309LSI / RW 309LMO / RW309H is a 309-series stainless welding wire class for joining stainless steels to carbon steels and other dissimilar materials. RW 309L supports corrosion resistance with low carbon, RW 309LSI adds improved fluidity, penetration and bead appearance. RW 309SI is suitable for heat-resistant steels, including CrSiAl grades, and oxidizing gas environments with about 8% ferrite in the weld metal. RW 309LMO adds Mo for improved pitting resistance in chloride environments, RW309H is used where high-temperature performance is required.

### EXPECTED MINIMUM MECHANICAL PROPERTIES AS WELDED

	MIG	TIG	SAW
Rp0,2 [MPa]	460	-	-
Rp1 [MPa]	-	-	-
Rm [MPa]	610	-	-
A [%]	35	-	-
Z [%]	52	-	-
Impact Energy, ISO-V 20°C	117	-	-
Impact Energy, ISO-V -20°C	-	-	-
Impact Energy, ISO-V -60°C	102	-	-
Impact Energy, ISO-V -110°C	-	-	-
Impact Energy, ISO-V -120°C	-	-	-
Impact Energy, ISO-V -196°C	-	-	-

### DIAMETER

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<b>Mn</b>	1,00	2,50
<b>Si</b>	0,65	1,00
<b>S</b>	-	0,020
<b>P</b>	-	0,030
<b>Cr</b>	23,0	25,0
<b>Ni</b>	12,0	14,0
<b>Mo</b>	-	0,30
<b>Cu</b>	-	0,30
<b>N</b>	-	-
<b>Nb</b>	-	-
<b>Ti</b>	-	-

### PACKAGING

<b>MIG</b>	Blue Metallic Wire Basket BS300: 15 Kg. Plastic Spool D300: 15 Kg. Plastic Spool D200: 5 Kg. Wooden/Metallic Bulk Spool: 250 Kg. Drum: 250-400 Kg.
<b>TIG</b>	Carton Boxes/Tubes: 5 Kg. (1000 mm Rod Length)
<b>SAW</b>	Metallic Wire Basket K415 Wooden/Metallic Bulk Spool: 250 Kg. Drum: 300 Kg.

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## TECHNICAL DATASHEET - WELDING CONSUMABLE

<b>AWS Code:</b>	-
<b>Product Code:</b>	RW 309LMO
<b>Werkstoff No.:</b>	(1.4459)
<b>MIG Certification:</b>	CE
<b>TIG Certification:</b>	CE

### EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
23 12 2 L	-	-	-

### DESCRIPTION AND APPLICATIONS

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<b>C</b>	-	0,03
<b>Mn</b>	1,00	2,50
<b>Si</b>	0,30	0,65
<b>S</b>	-	0,020
<b>P</b>	-	0,030
<b>Cr</b>	21,0	25,0
<b>Ni</b>	11,0	15,5
<b>Mo</b>	2,00	3,50
<b>Cu</b>	-	0,30
<b>N</b>	-	-
<b>Nb</b>	-	-
<b>Ti</b>	-	-

### DIAMETER

<b>MIG sizes</b>	0,8   0,9   1,0   1,14   1,2   1,6
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