

LNT 309L

CLASSIFICATION

AWS A5.9	ER309L	A-Nr	8	Mat-Nr	1.4332
ISO 14343-A	W 23 12 L	F-Nr	6		
		9606 FM	5		

GENERAL DESCRIPTION

Solid rod for welding stainless steel to carbon steel

SHIELDING GASES [ACC. ISO 14175]

II Inert gas Ar (100%)

APPROVALS

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo
0.01	1.65	0.5	24	13	0.1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)
Typical values	II	AW	390	600	35

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	Mat. Nr	ASTM	UNS
Corrosion resistant cladsteels	X2CrNiN18-10	1.4311	(TP)304LN	S30453
	X2CrNi19-11	1.4306	(TP)304L	S30403
			CF-3	J92500
	X4CrNi18-10	1.4301	(TP)304	S30400

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.0	2.4
5 kg PE-Tube	X	X	X

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