

309S92

SAW

309L SOLID WIRE FOR SAW

PRODUCT DESCRIPTION

Solid wire for sub-arc welding.

CLASSIFICATIONS

AWS A5.9M	ER309L
ISO 14343-A	S 23 12 L
ISO 14343-B	SS309L
APPROVALS	TÜV

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min.	--	1.0	0.30	--	--	23.0	12.0	--	--	8
Max.	0.03	2.5	0.65	0.020	0.030	25.0	14.0	0.3	0.3	20
Typical	0.015	1.7	0.5	0.005	0.015	23.5	13	0.1	0.15	12

ALL-WELD MECHANICAL PROPERTIES

As welded

Tensile strength [MPa]

0.2% proof strength [MPa]

Elongation [%] 4d
5d

Reduction of area [%]

Impact ISO-V[J] +20°C
-20°C
-75°C

Hardness cap/mid HV

TYPICAL OPERATING PARAMETERS

Flux	Current	Diameter (mm)	Parameters
P2007***	DC+	2.4	350A,28V

**SSB also suitable.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
2.4	25	B415	SA309S92-24
3.2	25	B415	SA309S92-32