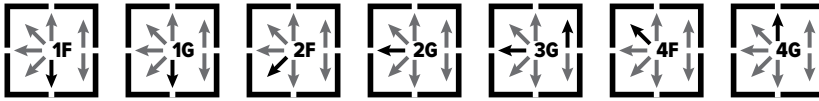


STAINLESS STEEL

HYPERTIG 309L



Summary

HYPERTIG 309L is a stainless steel welding rod specifically formulated for welding dissimilar steels between stainless to mild or carbon steels. As an austenitic stainless steel filler, it offers excellent corrosion resistance, particularly against environments that cause sulfide stress cracking. The low carbon content in the 309L minimises carbide precipitation and makes it more resistant to intergranular corrosion.

Typical Applications

- Joining stainless steels to carbon or low-alloy steels
- Overlay work on carbon steels
- Stainless structures exposed to elevated temperatures
- Situations demanding a buffer layer between dissimilar metals
- Repair of mixed metal assemblies

Classification

- AS/NZS ISO 14343

Standards

- AWS A5.9: ER309L
- AS/NZS ISO 14343: W 309L

Approvals

- Lloyds Register of Shipping
- ISO
- CE

Packaging Info

SKU	FILLER ROD SIZE	WEIGHT	DESCRIPTION
TI309L-1.6	1.6mm	5kg	HYPERTIG 309L STAINLESS STEEL 1.6MM 5KG
TI309L-2.4	2.4mm	5kg	HYPERTIG 309L STAINLESS STEEL 2.4MM 5KG

Recommended Gas

- Ar 100%
- Ar + 10-30% He
- Ar + 50-75% He

Operating Polarity

- DCEN

Typical Chemical Composition (%)

C	Mn	Si	P	S	Ni
0.022	1.920	0.400	0.027	0.010	12.170
Cr	Mo	Cu	N2		
23.210	0.016	0.037	0.135		

Typical Mechanical Analysis

YIELD STRENGTH	485
TENSILE STRENGTH	628
ELONGATION	36
ABSORBED ENERGY (J)	102