

## DATASHEET RW 309 L – TIG Rods

### Description and Applications

Austenitic stainless steel TIG rod, suitable for welding steels such as AISI 309, but also used to weld dissimilar steels and for buffer layers. The RW 309 L has a low C content which reduces the possibility of intergranular carbide precipitation and therefore it increases the resistance to intergranular corrosion. It has excellent high temperature oxidation resistance.

### Rodacciai denomination and approximate equivalent with other standards

	<b>RW 309 L</b>
EN ISO 14343-A:2009	W 23 12 L
EN ISO 14343-B:2009	SS 309 L
AWS A5.9-2012	ER 309 L
DIN Werkstoff Nr.	1.4332

**Approvals**  
CWB

### Filler metal properties

Chemical composition (nominal) in %

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	N	Nb	B
min		1,50	0,30			23,00	13,00						
max	0,020	2,00	0,50	0,015	0,020	24,00	14,00	0,30	0,20	0,20	0,060	0,050	0,003

### Metal properties

The following data are typical for non-heat treated weld metal from TIG welding with I1 DIN EN ISO 14175 as shielding gas.

### Expected minimum mechanical properties of all weld metal

Temperature	°C	20
Yield strength, Rp 0,2	N/mm <sup>2</sup>	350
Yield strength, Rp 1,0	N/mm <sup>2</sup>	380
Tensile strength, Rm	N/mm <sup>2</sup>	520
Elongation, A5	%	30
Impact energy, ISO – V	J	70

### Sizes and marking

Standard sizes : diam. 1,00 – 1,20 – 1,60 – 2,00 – 2,40 – 3,20 and 4,00 mm

Tolerances on diameter : + 0,01 / - 0,04 mm

Marking : Each rod is stamped one end with ER 309L and RW 1.4332

### Packaging forms

White carton boxes of 5 kg.

Red, white or blue coloured cardboard tubes of 5 kg.

Wooden crates of 250 kg.