

MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 309L is a stainless steel solid wire suitable for welding austenitic-ferritic steels with 25% Cr and 12% Ni, for applications up to 300°C. Inertfil 309L can be supplied with Carbon= 0.12% max.

Classification	
AWS	A5.9: ER 309L
EN	12072: G 23 12L

Approvals	Grades
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.02	1.80	0.45	≤ 0.030	≤ 0.020	24	13	-	-	-	-	10-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 350	≥ 520	≥ 30	≥ 47	-

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1)

Materials

A312 TP309S; carbon steel to stainless steels joining

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: BS300 Kg. 15

Diameters	0,8	1,0	1,2			
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