



EWB[®] – ER 309L MIG / TIG Welding Wires

Classifications:

EN ISO 14343-B:2007 : SS 309L
AWS A5.9: ER309L

Material No. 1.4332

Typical Chemistry Composition of Weld Deposit:

C	Cr	Ni	Mn	Si
<0.03	23.00 – 25.00	12.00 – 14.00	1.00 - 2.50	0.30 - 0.65

Description:

- MIG / TIG welding of 22%Cr-12%Ni STS and dissimilar steels such as 304L to mild steels or low alloy steels.

Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
min. 320	min. 520	min. 30

Welding Parameters:

Wire Diameter (Ø in mm)	0.80	1.00	1.20
Pulsed Arc (A)	100 - 150	120 - 200	140 - 220
Voltage (V)	22 - 27	24 - 28	24 - 28

Packing Available:-

MIG/MAG Wire (Ø in mm): 0.80 / 1.00 / 1.20

TIG Wire (Ø in mm): 1.60 / 2.40 / 3.20 / 4.00

EWB Weld

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