

DATA SHEET N. 3002

DAIKO SF 309L

MIG - TIG - SAW

Description / Alloy type: Solid wire for dissimilar joining and buffer layer.

Specifications: **AWS A5.9** **EN ISO 14343-A**
ER309L 23 12 L

Applications: These consumables are mainly used under high dilution conditions, particularly dissimilar welds between stainless and CMn steels. Also overlays on CMn steel or low alloy steel and for joining clad plate. Other application is welding of similar metal joints (23Cr-12Ni type).

Composition:
(weight %)

%	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	FN
Min	-	1.0	0.30	-	-	23.0	12	-	-	8
Max	0.030	2.5	0.65	0.020	0.030	25.0	14	0.3	0.3	20
Typ	0.015	1.7	0.50	0.005	0.015	23.5	13	0.1	0.15	12

Typical parameters:

	TIG	MIG
Shielding	Argon	Ar + 2% O ₂ Ar-He + <3% CO ₂
Current	DC-	DC+
Diameter	2.4 mm	1.2 mm
Parameters	100A, 12V	260A, 26V

All-weld proprieties:

As welded	Typ. TIG
Tensile strength [MPa]	590
0.2% proof stress [MPa]	450
Elongationon 4d [%]	43
Impact Energy +20°C [J]	150

Complementary products: SMAW electrode (AWS A5.4 E309L-15/16/17)
GMAW wire (ER309LSi)
FCAW wire (AWS A5.22 E309LT0-1/4 / E309LT1-1/4)
ESW strip (A5.9 EQ309L)