

# MIGINOX 309 / TIGINOX 309

**Classification**  
AWSA/SFA5.9 : ER 309

Approvals : MIGINOX 309  
RDSO Class VII

Approvals : TIGINOX 309  
TOYO ER 309

## Characteristics

A 24Cr 13Ni stainless steel filler wire with ferrite content of approx 15%. The weld metal has excellent oxidation and corrosion resistance in continuous service upto 1100C°.

## Typical Applications

For welding of stainless steels represented by AISI type 309. Suitable for buttering 18/8 Cr-Ni steels.

### Typical Wire Chemistry

C	Mn	Si	Cr	Ni	S	P
0.12 max	1.0-2.5	0.30-0.65	23-25	12-14	0.030 max	0.030 max

Properties of weld metal with 98% Ar + 2% O<sub>2</sub> gas Current Condition : DC (+) in GMAW

### Classifications:

All Weld Mechanical Properties As welded condition

UTS MPa	550
Elongation % (L=4xd)	30-38
The chemistry & mechanical properties of the weld will vary with the type of shielding gas used.	

### Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 12.5 Kg

### Packing Specifications for MIGINOX 309

Size mm	2.0	1.6	1.2	0.80
Kgs	12.5	12.5	12.5	12.5

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

### Packing Data for TIGINOX 309

Dia., mm	1.6	2.0	2.5
Length,mm	1000	1000	1000
Net wt per tube,kg	5	5	5
No of Plastic Tubes per Box	4	4	4
Net wt,Box,kg	20	20	20



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