

MIGINOX 309L / TIGINOX 309L

Classification
AWS A/SFA 5.9 : ER 309L

Approvals : MIGINOX 309L

Approvals : TIGINOX 309L
NPCIL
TOYO ER 309L

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 1100°C.

Typical Applications

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

Typical Wire Chemistry

C	Mn	Si	Cr	Ni	S	P
0.03 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% O₂ gas shielding Current Condition:DC (+) in GMAW

Classifications:

All Weld Mechanical Properties - As welded condition

UTS MPa	520 min
Elongation % (L=4xd)	30-40
The chemistry and mechanical properties of the weld metal 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 309L

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 309L

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

Special Test :

Test Type	Remarks
IGC (As per ASTM - A 262)	* MIGINOX - 309L passed in practice - "E"



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