

OK Autrod 309L

A continuous solid corrosion resisting chromium-nickel wire for joining stainless steels to non-alloy or low alloy steels as well as welding of austenitic stainless alloys of 24% Cr, 13% Ni types.

The wire has a good general corrosion resistance. When used for joining dissimilar materials the corrosion resistance is of secondary importance.

OK Autrod 309L can be used in combination with OK Flux 10.92, OK Flux 10.93 and OK Flux 10.99.

Classifications Wire Electrode	SFA/AWS A5.9 : ER309L EN ISO 14343-A : S 23 12 L
Approvals	CE EN 13479 NAKS/HAKC 1.6-4.0 mm VdTUV 12101

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 12 % ferrite) 24 % Cr - 13 % Ni - Low C
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Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.02	1.8	0.4	13.4	23.2	0.10	0.05	10