

Shield-Bright 309L

Shield-Bright 309L is a rutile cored wire designed for the all-positional welding (except vertical down) of stainless steels to carbon or low alloy steels and for the first layer cladding of carbon and low alloy steels with Ar/15-25%CO₂ or CO₂ shielding gas.

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|-----------------------------------|--|
| Classifications Weld Metal | SFA/AWS A5.22 : E309LT1-4 SFA/AWS A5.22 : E309LT1-1 JIS Z 3323 : TS309L-FB1 KS D 3612 : YF-309LC EN ISO 17633-A : T 23 12 L P C1 2 EN ISO 17633-A : T 23 12 L P M21 2 |
| Approvals | RS A-9sp(x8CrNi 24 14) (C1) NAKS/HAKC 1.2 mm LR SS/CMn (M21) ABS E309LT1-1 (C1) ABS E309LT1-4 (M21) BV 309L (C1) CCS 309L (C1) CE EN 13479 ClassNK KW309LG(C) (C1) CWB E309LT1-1 (C1) CWB E309LT1-4 (M21) DNV-GL VL 309L (C1) DNV-GL VL 309L (M21) KR RW309LG(C) (C1) LR SS/CMn (C1) VdTUV 04833 (M20 M21) |

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

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|------------------------|------------------|
| Welding Current | DC+ |
| Alloy Type | Austenitic Cr-Ni |

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|-------------------|----------------|------------------|------------|
| M21 shielding gas | | | |
| C1 shielding gas | | | |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|------------------|---------------------|--------------|
| C1 shielding gas | | |
| As Welded | -29 °C | 55 J |
| As Welded | -196 °C | 18 J |

Current Range

| Diameter | Current | Voltage |
|----------|-----------|---------|
| 1.2 mm | 130-220 A | 24-29 V |