



**MANUFACTURERS OF A DIVERSE RANGE OF
ADVANCED WELDING CONSUMABLES**

**SECTION
13**

WI-0304 DS168 NSN-309LR, Rev. 0, Date 01.09.2008

NSN-309LR	FILLER ROD FOR WELDING LOW-CARBON AUSTENITIC STAINLESS STEELS CONTAINING A NOMINAL 23Cr-12Ni USED FOR DISSIMILAR WELDS BETWEEN STAINLESS AND C-Mn STEELS										DATA SHEET NO. 168
	SPECIFICATION	AWS A5.9			JIS Z 3321			BS EN 12072			
CLASSIFICATION	ER309L			Y309L			W 23 12 L				
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Fe
	MIN	-	23	12	-	1.0	0.3				
	MAX	0.03	25	14	0.75	2.5	0.65	0.03	0.03	0.75	
	TYPICAL	0.02	23.5	13.5	0.1	1.5	0.45	0.02	0.001	0.2	Bal.
WELD METAL PROPERTIES (ALL WELD METAL)	<u>PROPERTY</u>		<u>UNITS</u>		<u>MINIMUM</u>		<u>TYPICAL</u>		<u>OTHERS</u>		
	Tensile strength		N/mm ²		520		600				
	0.2% Proof stress		N/mm ²		-		440				
	Elongation on 4d		%		30		42				
	Impact energy -75 °C		J		-		160				
OTHER DATA	Argon mainly use as shielding gas										
RELATED PRODUCTS	Please contact our Technical Department for detail.										