

# Product Data Sheet

## STAVINOX TIG 309L

**SS TIG WELDING WIRE**  
Stainless and Heat resistant steels

### Classification :

AWS A 5.9 : ER 309 L  
EN 12072 : W 23 12 L

**Description:** STAVINOX TIG 309L is a stainless TIG rod conforming to ER 309L for welding austenitic stainless steels such as AISI 309. It is also used to weld dissimilar steels and for buffer layers and buttering 18 Cr/ 8 Ni steels. Excellent oxidation and corrosion resistance in continuous service up to 1100°C. Ferrite content is 15% approx.

### Materials to be welded

A312 TP309S; carbon steel to stainless steels joint .

### Typical Chemical Composition (%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.03 max	1.50-2.20	0.30-0.65	23.00-25.00	12.00-14.00	0.75 max.	0.75 max.	0.03 max.	0.03 max.

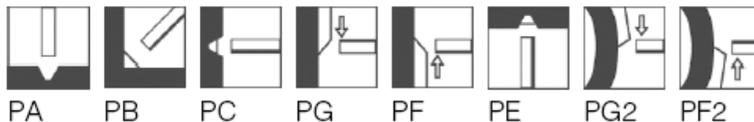
### Typical All Weld Mechanical Properties

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO-V(J) 20° C
≥ 350	≥ 520	≥ 30	≥ 47

**Current Conditions:** - DC (-)

**Storage:** - Keep dry and avoid condensation.

### Welding Position:-



### Packing Data

Size(mm) DxL	0.80 x 1000	0.90 x 1000	1.00 X1000	1.20 X 1000	1.60 x 1000	2.00 x 1000	2.40 x 1000	3.20 x 1000	4.00 x 1000
Net wt. per tube( kg)	5	5	5	5	5	5	5	5	5
Net wt. per Box( kg)	20	20	20	20	20	20	20	20	20