

DIF-FILL 109

STAINLESS STEEL FILLER WIRE 309L FOR
 TIG , MIG , MAG WELDING

DIF-FILL 109 an austenitic stainless steel filler wire, typically contains extra low carbon and 24 % Cr, 13 % Ni. used for the welding of type 309, 309L steels as well as dissimilar combinations of steels. The low carbon in weld metal increases resistance to intergranular corrosion/cracking without use of stabilizing elements such as Ti or Nb. Produces excellent weld metal finish at DC(-) with Argon as a shielding gas.

Applications:

Joining and surfacing of 25 Cr/ 12 Ni alloys in wrought or cast forms. Commonly used for joining of dissimilar steels e.g. stainless steel to mild steels or stainless steel to low alloy steels. Welding clad side of type 304, 304L, clad steels.

Specification:

AWS / SFA 5.9 : ER 309 L

Alloy Basis: (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Fe
0.025 max	0.3-0.65	1.0 – 2.5	23 - 25	12 - 14	0.5 max	0.5 max	BAL

Properties:

Applicable Gas : Welding Grade Argon gas.
 Argon + 2.5 % Co₂
 Tensile strength : 540 N/mm
 Elongation : 37 %

Packing Standards:

Size (dia mm) - 1.6 mm, 2.0mm, 2.5mm, 3.15mm, 4.00mm
 Length - 1000 mm
 Packing - 5 kg per packet, 20 kg per case
 Spool - MIG welding 0.8 mm, 1.2mm, 1.6 mm, 12.5 kg per spool.

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