

MIGWELD 309H

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : G 22 12 H DIN 8556 : SG-X12 CrNi24 12 AWS A-5.9 : ER 309 W.Nr. : 1.4829		Power generation industry Constructions & Engineering Petrochemical and chemical industry Shipbuilding&Offshore

- High carbon stainless steel welding wire for high temperature applications.
- Resistant to scaling up to 1050°C.
- Used as a buffer layer before hardfacing as well as for cladding and joining similar austenitic steels.
- Very good mechanical properties and very good weldability, suitable for high temperatures up to 1100°C.
- Good resistance to abrasion and sulfidation.

Application

Most commonly used in furnace components. Petrochemical and cement plants.

Base material

DIN	W.Nr.	AISI/ASME
X15 CrNiSi20 12	~1.2780	~308
X6 CrNiTi18 10	1.4541	321
X6 CrNiNb18 10	1.4550	347H
X10 CrSi6	1.4712	
X10 CrAl13	1.4724	405
X10 CrAl18	1.4742	442
G-X25 CrNi18 9	1.4825	
X15 CrNiSi20 12	1.4828	309
GX40 CrNiSi22 9	1.4826	
G-X30 CrSi6	1.4710	
X10 CrAl13	1.4713	502
G-X40 CrSi13	1.4729	
G-X40 CrSi17	1.4740	
G-X25 CrNiSi20 14	1.4832	
X12 CrNiTi18 9	1.4878	
G-X25CrNiSi20-14	1.4832	
G-X40CrNiSi25-12	1.4837	

Typical chemical composition %

C	Si	Mn	Cr	Ni
0,07	0,40	1,70	23,50	13,50

Typical mechanical properties

Yield strength Re [N/mm2]	>400
Tensile strength Rm [N/mm2]	550-700
Elongation A5 [%]	>25
Impact energy Kv [J]	>70 J (20°C) /

Hardness	app. 235HB /
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	I1 - Ar / M12 - Ar + 0.5 - 5% CO2 / M13 - Ar + 0.5 - 3% O2 /

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
1,0	80-240	15-28	15,0
1,2	100-300	15-29	15,0

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