

AX-309L AX-4332

Material no.: 1.4332

Standards

EN ISO 14343-A:	W 23 12 L Si / G 23 12 L Si
EN ISO 14343-B:	SS309LSi
AWS A5.9:	ER309LSi

Properties

Welding rod/solid wire made of austenitic chromium-nickel steel with low carbon content and increased ferrite content for TIG or MAG welding of stainless claddings, dissimilar steels (dissimilar joints) and buffer layers.

claddings and buffer layers are already corrosion-resistant in the first layer. No risk of martensite formation (root welding) even at higher melting degrees with unalloyed materials.

Operating temperatures for dissimilar joints maximum 300 °C. Nickel-based welding consumables must be used for operating temperatures above 300°C and annealing treatments.

Important base materials / important applications

Joints of stainless ferritic Cr steels and austenitic Cr-Ni (Mo) steels with each other and with unalloyed steels (dissimilar joints), unalloyed and alloyed quenched and tempered steels and for the first layer of chemically resistant Cr-Ni-claddings.

Typical composition of the welding rod / solid wire in %

C	Si	Mn	Cr	Ni
0.02	0.9	1.8	23.3	13.1

Mechanische Gütewerte des reinen Schweißgutes (typische Werte)

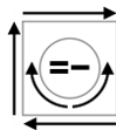
Yield strength $R_{p0.2}$	[MPa]	430
Tensile strength R_m	[MPa]	600
Elongation A ($L_0 = 5d_0$)	[%]	32
Impact energy KV	[J]	100 at +20°C

Shielding gas: 100% argon, PWHT: untreated

Operating data

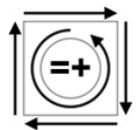
TIG:

Shielding gas: I1 (100%Argon)
acc. to ISO 14175



GMAW:

M12 (z.B. Ar+2.5%CO₂)
M13 (z.B. Ar+max.1.0%O₂)



Approvals

(Please ask for current scope)

Packaging and available sizes

Spools	Ø mm	0.8	1.0	1.2	1.6		
Rods	Ø mm x 1000mm	1.6	2.0	2.4	3.2		

Other dimensions on request.