

**TIG Rods****Stainless and Heat resistant steels**

Inertrod 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. Excellent high temperature oxidation resistance.

Classification	
AWS	A5.9: ER 309L
EN	12072: W 23 12L

Approvals	Grades
TÜV	see Appendix, Classification Society Approvals, for details pag. 521

**Analysis of all-weld metal (Typical values in %)**

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.02	1.80	0.45	≤ 0.030	≤ 0.020	24	13	-	-	-	-	10-20

**All-weld metal Mechanical Properties**

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

Gas test: Acc. To EN 439: I1(Arcal1)

**Shielding Gas:** Acc. To EN 439: I1(Arcal1)

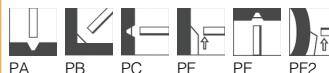
**Materials**

A312 TP309S; carbon steel to stainless steels joint

Storage
Keep dry and avoid condensation

**Current condition and welding position**

DC-



**Packaging data:** Tube 5 kg

Diameters (L: 1000 mm)	1,2	1,6	2,0	2,4	3,2	
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Further forms of delivery on request.