HILCO Hilchrome W309L

TIG rods - stainless steel - special purpose

AWS A5.9: ER 309L
EN ISO 14343-A: W 23 12 L
Werkstoffnr. 1.4332

Wire type:
TIG Solid wire

Current:

Welding positions:

Shielding gas:
I1 = Pure Ar

Hilchrome W309L is our solid wire for TIG welding corrosion resistant and heat resistant CrNi steels, joining dissimilar metals and buffering. Typical applications include joining high-strength steels, un- and low alloyed heat treatable steels, stainless, ferritic chromium and austenitic chrome-nickel steels, austenitic manganese steels. Hilchrome W309L is suitable for joining clad steels. The FN content (FN ~16) ensures good cracking resistance. To be used in combination with tungsten electrodes type WS2 Witstar®.

Base materials to be welded:

- High strength, unalloyed and alloyed heat treatable steels; stainless, ferritic chromium and austenitic CrNi steels; austenitic manganese steels
- Chemically resistant weld claddings ranging from ferritic-pearlitic steels to fine grain steels, incl. high temperature fine grain steels
- Dissimilar joining

Applications:

- Power Generation
- Repair & Maintenance
- Oil & Gas Industry
- Process Industry

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
Hilchrome 309R	Hilchrome W309L	-	-	-	-

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,03	2,00	0,40			24,0	13,0					

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 400	≥ 550	≥ 30	+20ºC ≥ 55

Notes: properties under pure Argon gas shielding

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
1,6	1000	5
2,0	1000	5
2,4	1000	5
3,0	1000	5