

# Stainless Steel MIG • TIG Wire / Rod

## GM309L / GT309L

AWS A5.9 ER309L  
JIS Z 3321 YS309L  
ISO 14343-A-G 23 12 L  
14343-A-W 23 12 L

### Product Features:

- Low carbon content, Austenite weld metal contains adequate ferrite, good heat and crack resistance.

### Applications:

- Cladding or welding of stainless steel to carbon steel or low alloy steel.

### Shielding gas:

- Ar+ 1~2% O<sub>2</sub> (MIG)
- 100%Ar (TIG)

Typical chemical composition of wire / rod (wt%)

| C    | Si   | Mn   | Ni    | Cr | Fe   |
|------|------|------|-------|----|------|
| 0.02 | 0.47 | 1.53 | 13.67 | 23 | Bal. |

Typical mechanical properties of all weld metal

| Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>% |
|-------------------------------------|---------------------------------------|-----------------|
| 558                                 | 632                                   | 40              |

MIG wire Size & recommended welding parameters; DC+

| Diameter (mm)       | 0.9/1.0 | 1.2    | 1.6     |
|---------------------|---------|--------|---------|
| Current range (Amp) | 70~200  | 90~250 | 200~300 |

TIG rod size diameter/length; DC-

| Diameter (mm) | 1.6  | 2.0  | 2.4/2.6 | 3.2  |
|---------------|------|------|---------|------|
| Length (mm)   | 1000 | 1000 | 1000    | 1000 |

### Note:

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