

# Lincoln® TIG 309L

## Key Features

- Double stamped for optimum traceability

## Typical Applications

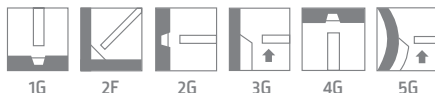
- Excellent for welding dissimilar metals e.g. stainless steel to carbon steel
- Build up welding on mild and low alloy steels
- Buffer layers before hard facing

## Conformances

AWS A5.9:

ER309L

## Welding Positions



## Shielding Gas

- 100% Argon
- Flow rate 10-15 L/min

## Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.4	1000	365294	PE Tube 2kg
3.2	1000	365295	PE Tube 2kg

## Mechanical Properties - As required per AWS A5.9

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -46°C
Typical Results - As Welded	400	590	35	65

## Deposit Composition

	%C	%Mn	%Si	%Ni	%Cr	%Mo
Typical Results - As Welded	0.012	1.6	0.5	13.6	23.0	0.1