



AMA 30-17 M

Standards: AWS/ASME SFA-5.9

ER 309 L

Application/ Properties: Austenitic - ferritic wire electrode for MIG/ MAG welding of high alloy steels to unalloyed or low alloy steels. Highest operating temperature is 300 C.

Wire Analysis:

C	Si	Cr	Mn	Ni
<0.03	0.3-0.65	23-25	1-2.5	12-14

Shielding gas: DIN EN 439 -M13 (0-3% O₂, Balance Ar)

DIN EN 439 -M12 (0 -5% CO₂, Balance Ar)

Mechanical properties of all -weld metal :

Tensile Strength (N/mm ²)	0.2% Proof Stress (N/mm ²)	Elongation Lo = 4d %	Impact energy (j) ISO - V 25 °C
>520	>400	>30	>47

Material:

DIN EN standard 1.4406 X2CrNiMoN 17 12 2 ; 1.4401 X5CrNiMo 17 12 2 ; 1.4404 X2CrNiMo17 13 2 G-X2CrNiMoN 18 10 ; 1.4311 X2CrNiN 18 10

other Standard ASTM/ACI A240/A312/A351 : (TP)304LN ; (TP)304L ; CF-3 ; (TP)304

Delivery: Only wound wire - reel on:

weight :15kg.

diameter : 0.8 -1.6 mm

Note: other weight & sizes are produced upon customers request.

