



## AMA 30-17 T

**Standards:** AWS/ASME SFA-5.9

ER 309 L

**Application/ Properties:** Austenitic-ferritic welding rod for TIG welding of high alloy steels to unalloyed steels. Highest operating temperature is 300 C.

### Wire Analysis:

| C      | Si        | Cr    | Mn    | Ni    |
|--------|-----------|-------|-------|-------|
| <0.030 | 0.30-0.65 | 23-25 | 1-2.5 | 12-14 |

**Shielding gas:** 100% Argon

### Mechanical properties of all -weld metal :

| Tensile Strength<br>(N/mm <sup>2</sup> ) | 0.2% Proof Stress<br>(N/mm <sup>2</sup> ) | Elongation<br>Lo = 4d<br>% | Impact energy (j)<br>ISO - V<br>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:** welding rods

weight :5 kg.

diameter : 1- 4 mm.

Length: 1000mm.

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

