

**Technical  
data sheet**

011121MBA

**Cored welding wire**  
**TRI S 309L-O****CLASSIFICATION**

EN ISO 17633-A:	T 23 12 L U NO 3
ASME IIC SFA 5.22 / AWS A 5.22:	E309LT0-3
EN ISO 17633-B:	TS309L-F NO 0
Equivalent Material number :	1.4332
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

**DESCRIPTION**

- Special flux cored self shielded stainless steel wire for open arc welding
- 24% chromium - 13% nickel - low carbon deposit
- The weld beads produced have a self-releasing slag covering that leaves a clean surface
- Sound deposits are obtained even in the presence of cross draughts
- Primary choice for cladding and rebuilding application
- Suited for joining
- Provides maximum productivity for outdoor jobs

**APPLICATIONS**

The TRI S series of wires is designed for on-site weld surfacing, repair and assembly of stainless steels. Good quality welds may be obtained, even when they are used in difficult weather conditions. TRI S 309L-O is suitable for:

- Welding stainless steels of similar composition or ferritic stainless steels.
- Joining stainless steels to mild and low-alloyed steels.
- Rebuilding and buffering before cladding or hardfacing.
- Maintenance on « hard-to-weld steels ».

**Examples**

Dissimilar welds between stainless steels type 304, 304L, 316, 316L, 318, 316Ti, 321, 410 or ferritic stainless steels

**TYPICAL ALL-WELD METAL ANALYSIS**

C	Mn	Si	Cr	Ni	S	P
0.03	1.75	0.80	24.5	13.0	0.008	0.020

Typical ferrite level: 15 FN

**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
520	320	30	+ 20°C: 32

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
680	560	35	+ 20°C: 45

**SHIELDING GAS**

None

**OPERATING CONDITIONS**

Current type	Gas flow rate	Stick-out	Recovery
DC+	-	25 - 45 mm	88 %

**WELDING POSITIONS**

Flat, half up, half down

**PACKAGING**

Diameter	1.2 mm	1.6 mm	2.0 mm	2.4 mm
Spool type	EN ISO 544: BS300			
Weight	15 kg			

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.