Technical data sheet 011121MBA	Cored welding wire # TUBE S 309LNb-G	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	(EC309LNb)[1]
ASME IIC SFA 5.9 / AWS A 5.9:	(EC309LNb)[1]
EN ISO 17633-A:	T 23 12 Nb M M12 1
EN ISO 17633-B:	TS309LNb M M12 1

[1] This composition does not appear in ASME IIC SFA 5.9 (5.22) / AWS A 5.9 (5.22)

DESCRIPTION

- Metal cored stainless steel wire for gas shielded arc welding
- 23% chromium - 12% nickel - niobium stabilised - low carbon deposit
- Combines the quality of SMAW with the productivity of GMAW
- Excellent weld metal quality and X-ray soundness

APPLICATIONS

TUBE S 309LNb-G is suitable for cladding carbon and low alloy steels and produces a niobium stabilized first layer on such claddings.

Examples:

AISI	UNS	Material number	EN Symbol
321	S32100	1.4541	X6 CrNiTi 18-10
347	S34700	1.4550	X6 CrNiNb 18-10

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Nb	S	P
0.02	1.50	0.5	23.0	12.5	0.8	0.008	0.020

Typical ferrite level: 20 FN

SHIELDING GAS

EN ISO 14175:	M12	Ar + 0.5 % < CO_2 ≤ 2.5 with or without helium
	Z	Ar + CO_2 ≤ 0.5 % or O_2 ≤ 0.5 % with or without helium
	I1	Ar
	M13	Ar + 0.5 % < O_2 ≤ 3.0 with or without helium

OPERATING CONDITIONS

Current type	Gas flow rate	Stick out	Recovery
DC (+) / pulsed	10 - 20 l/min.	12 - 25 mm	98 %

WELDING POSITIONS

EN ISO 6947: PA, PB
ASME IX: 1G, 1F, 2F
TUBE S 309LNb-G is primarily used in the flat and horizontal positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

PACKAGING

Diameter	1.2 mm		1.6 mm
	EN ISO 544 – ASME IIC SFA-5.2 M		
Spool type	S200	BS300	BS300
Weight	5 kg	15 kg	15 kg

Other packaging and other diameters: please consult us