MIG 24/12C

Classification

AWS A5.9 : ER309 ISO 14343-A : G 22 12 H

Description & Applications

High carbon solid wire for GMAW of stainless steels with similar chemical composition like 309. Well adapted for welding of dissimilar steels like low alloy steels, ferritic stainless steel like 430, martensitic stainless steel like 410.

Main applications: Boiler making, civil engineering, maintenance and repairs…

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Co	N	Fe
Min	0.04		1.0	23.0	12.0								
Max	0.12	0.65	2.5	24.0	14.0	0.5	0.5	-	0.03	0.02	-	-	Rem.
Type	0.08	0.40	1.7	23.4	13.2	0.10	0.08	0.01	0.02	0.01	0.06	0.06	Rem.

All Weld Metal Mechanical Properties

	R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	350	550	25	-	-
Max					
Type	400	600	30	+20°C	140

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8 1.0 1.2 1.6	70 - 180 80 - 220 150 - 320 220 - 380	18 - 26 18 - 28 22 - 32 24 - 34	ISO 14175: M12 (Ar+0.5-5%CO_2) M13 (Ar+0.5-3%O_2) 15-20 l/min

Back shielding with Argon or Nitrogen gas or with copper backing support to avoid “back end” rust phenomena.

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