TIG 24/12M

Old reference: TIG 309LMo

Classification

ISO 14343-A : W 23 12 2 L
AWS A5.9 : ~ER309LMo

Material N° : 1.4459

Description & Applications

Rod for Gas Tungsten Arc Welding for joining of stainless steels, 23 Cr - 12 Ni - 2 Mo type, used to weld on 316L stainless steels and for dissimilar joints between construction / mild steels and stainless steels. Used for intermediate layer for a 316L type cladding and buffer layer before hardfacing. Highly crack resistant. Highly corrosion resistance.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe	FN
0.015	0.55	1.5	21.5	14.5	2.6	0.1	<0.02	<0.01	Rem.	~ 12

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
400	600	35	20°C 120

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon or Nitrogen/H_2 : 3 - 6 l/min

Ind.11

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.