MT-309 L 1.4332

TIG/MIG welding wire of austenitic chrome nickel steel, very low carbon content, for cladding on stainless and dissimilar steels.
Weld metal suitable for working temperatures of up to +300°C

Standard designation

Material No.	1.4332
AWS/ASME SFA-5.9	~ER 309 LSi
EN ISO 14343-A	G/W 23 12 LSi

Main fields of application

Dissimilar steels (joint welds of austenitic to ferritic steels) cladding and buffer layer welding.

Main base metals

Heat – proof and non – scaling steels e.g.

1.4710	G-X 30 CrSi 6	1.4825	G-X 25 CrNiSi 18 9
1.4729	G-X 40 CrSi 13	1.2780	X 15 CrNiSi 20 12
1.4740	G-X 40 CrSi 17	1.4828	X 15 CrNiTi 20-12

Mechanical properties of all – weld – metal (typical values)

Welding process **Gas shield** **Thermal treatment** **Test temperature**		**[°C]**	**TIG** **I1** **untreated** **+20°**	**MIG** **M11** **untreated** **+20°C**
0,2%-yield strength	$R_{p0,2}$	MPa	≥295	≥295
Tensile strength	R_m	MPa	≥510	≥510
Elongation	A_5	[%]	≥25	≥25
Impact strength	A_V	[J]	LNB	LNB

Average chemical composition of all - weld – metal (%)

C	Si	Mn	Cr	Ni
0,03	0,65-1,20	1,0-2,50	22,0-25,0	11,0-14,0

Structure

Austenite with increased delta ferrite standard

Gas types applicable TIG I1
Gas types applicable MIG M 11 and M 23

Approvals TÜV,CE

TIG rod diameters, unit weights

Diameter [mm]	**Length [mm]**	**Kg per box**
1,00	1000	10,0
1,60	1000	10,0
2,00	1000	10,0
2,40	1000	10,0
3,20	1000	10,0
4,00	1000	10,0
5,00	1000	10,0

MIG welding wires Diameter 0,8mm 1,0mm 1,2mm 1,6mm

Welding positions MIG acc.to EN ISO 6947 PA, PB, PF
Welding positions TIG acc.to EN ISO 6947 PA, PB, PC, PF, PE

Current/Polarity TIG **= -**
Current/Polarity MIG **= +**