

**FRO**

# ALTIG 309 L

## BAGHETE TIG / GTAW ROD

**CLASIFICARE / STANDARDS**

AWS A5.9-93 : ER 309 L  
EN 12072 : W 23 12 L

**OMOLOGAZIONI / APPROVALS****CARACTERISTICI PRINCIPALE**

Baghete TIG pentru sudarea otelurilor inoxidabile cu compozitie chimica similara si pentru sudarea imbinarilor eterogene dintre oteluri carbon si oteluri inoxidabile. Continutul scazut de carbon permite obtinerea de suduri rezistente la coroziune intergranulara. Pot fi utilizate pentru depuneri de straturi tampon inainte de depunerea straturilor tip 304 sau 304L.

**MAIN FEATURES**

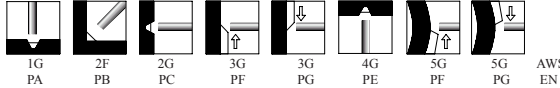
TIG rod for welding of austenitic stainless steel of similar composition and for different material welding with difficult weldability like carbon steel with stainless steel. The low carbon content allows to obtain welding resistant to intergranular corrosion. It can be used as buffer layer on carbon steel before welding with stainless steels type 304 and 304 L.

**DOMENII DE APLICATIE**

Constructii metalice  
Productia de automobile - electrocasnice  
Cazangerie inclusiv in ind. chimica/petrolifera  
Fabricarea tevilor

**MAIN APPLICATIONS**

Metal working industry  
Car, bus production and electro-domestic appliances  
Vessels, boilers fabrication including the chemical industry  
Pipes fabrication



CURRENT / CURRENT : DC -  
GAZ/ GAS : Ar (I1) EN 439

**ANALIZA CHIMICA A BAGHETEI % / ROD CHEMICAL ANALYSIS %**

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
≤ 0.03	1.00 - 2.50	0.30 - 0.65	≤ 0.03	≤ 0.03	23.00-25.00	12.00-14.00	≤ 0.75	≤ 0.75

**CARACTERISTICI MECANICE / MECHANICAL PROPERTIES**

GAZ	Trat. termic/Heat treatment	Rm N/mm <sup>2</sup>	Rp 0,2 N/mm <sup>2</sup>	E % 5d	Kv J +20° C
Ar	Stare sudata/As welded	≥ 520	≥ 205	≥ 35	≥ 47

**AMBALARE STANDARD / STANDARD PACKAGING**

Ambalare/ Packaging	Greutate/ Weight	Diametru mm x lungime mm / Diameter mm x lenght mm			
		1.6 x 1000	2.0 x 1000	2.4 x 1000	3.2 x 1000
Tubo/Tube	5 Kg	0840223	0840231	0840249	0840256

Datele mentionate pot fi modificate fara o notificare prealabila / The above data may change without prior notice.

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