

# Shield-Bright 309L

Shield-Bright 309L is a rutile cored wire designed for the all-positional welding, except vertical down, of stainless steels to carbon or low alloy steels and for the first layer cladding of carbon and low alloy steels with Ar/15-25%CO<sub>2</sub> or CO<sub>2</sub> shielding gas.

<b>Classifications Weld Metal:</b>	SFA/AWS A5.22:E309LT1-4, SFA/AWS A5.22:E309LT1-1, JIS Z 3323:TS309L-FB1, KS D 3612:YF-309LC, EN ISO 17633-A:T 23 12 L P C1 2 , EN ISO 17633-A:T 23 12 L P M21 2
<b>Approvals:</b>	CE EN 13479, BV 309L (C1), ABS E309LT1-1 (C1), CCS 309L (C1), ClassNK KW309LG(C) (C1), CWB E 309LT1-1 (C1), CWB E 309LT1-4 (M21), DNV NV 309L (C1), GL 4332S (C1), KR RW309LG(C) (C1), LR SS/CMn (C1), VdTÜV 04833 (M20,M21)

Approvals are based on factory location. Please contact ESAB for more information.

<b>Welding Current:</b>	DC+
<b>Alloy Type:</b>	Austenitic 309L

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>C1 Shielding gas</b>			
As welded	450 MPa	580 MPa	40 %

## Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
<b>C1 shielding gas</b>				
0.030	1.30	0.90	12.5	23.5

## Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	130-220 A	24-29 V	5.8-14.4 m/min	1.9-4.6 kg/h