



HILCO HILCHROME W309L

TIG rods – stainless steel – special purpose

AWS A5.9: ER 309L

EN ISO 14343-A: W 23 12 L

Werkstoffnr. 1.4332

Wire type:
TIG Solid wire

Current:



Welding positions:



Shielding gas:
I1

Hilchrome W309L is our solid wire for TIG welding corrosion resistant and heat resistant CrNi steels, joining dissimilar metals and buffering. Typical applications include joining high-strength steels, un- and low alloyed heat treatable steels, stainless, ferritic chromium and austenitic chrome-nickel steels, austenitic manganese steels. Hilchrome W309L is suitable for joining clad steels.

To be used in combination with tungsten electrodes type WS2 Witstar®.

Base materials to be welded:

- High strength, unalloyed and alloyed heat treatable steels; stainless, ferritic chromium and austenitic CrNi steels; austenitic manganese steels
- Chemically resistant weld claddings ranging from ferritic-pearlitic steels to fine grain steels, incl. high temperature fine grain steels
- Dissimilar joining

Applications:

- Power Generation
- Repair & Maintenance
- Oil & Gas Industry
- Process Industry

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	Cr	Ni
0,02	1,7	0,5	24,0	13,0

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 320	≥ 510	≥ 25	20°C ≥ 80

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
1,6	1000	5
2,0	1000	5
2,4	1000	5
3,2	1000	5