

## Classifications

<b>EN ISO 14343-A</b>	<b>AWS A5.9 / SFA-5.9</b>
S 23 12 L	ER309L

## Characteristics and typical fields of application

Thermanit 309L is a solid wire for submerged arc welding. For joining of stainless Cr and similar austenitic CrNiMo steels / cast steel grades. For joining of dissimilar materials. For tough joints on high manganese steel (steel castings), CrNiMn steels/cast steel grades and armour steels. For surfacing and repair welding on wear-exposed parts: rotors, rails. Especially suited for austenitic-ferritic joints at max. application temperature 300 °C. Particularly for tough joints of unalloyed/low-alloy steels / cast steel grades or stainless heat resistant Cr steels / cast steel grades with austenitic steels / cast steel grades.

### Recommended SAW flux:

Marathon 203    Marathon 801  
 Marathon 213    Marathon 805  
 Marathon 431

## Base materials

Welding and dissimilar joining of high-strength, mild steels and low-alloyed constructional steels; quench tempered steels, armour plates and austenitic manganese steels. Welding of non-alloyed as well as alloyed boiler or constructional steels to high-alloyed stainless Cr and CrNi-steels.

## Typical analysis

	C	Si	Mn	Cr	Ni
wt.-%	0.01	0.50	1.8	24	13.5

## Operating data

### Dimension mm

2.4  
 3.2  
 4.0

## Approvals

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