

**Classifications**

EN ISO 14343-A	EN ISO 14343-B	AWS A5.9	Mat. No.
W 23 12 L	SS309L	ER309L	1.4332

**Characteristics and typical fields of application**

Stainless. Well suited for depositing intermediate layers when welding clad materials. Favorably high Cr- and Ni-contents, low C content. For joining unalloyed/low-alloy steels/cast steel grades or stainless heat resistant Cr-steels/cast steel grades to austenitic steels/cast steel grades. For depositing intermediate layers when welding the side of plates clad with low-carbon – non-stabilized and stabilized CrNi(MoN)-austenitic metals.

Application temperature max. 300°C (572 °F).

**Base materials**

TÜV-certified parent metal.

Combinations between 1.4583 – X10CrNiMoNb18-12 and ferritic steels up to S355N.

Joints of and between HSLA, unalloyed and alloyed quenched and tempered steels, stainless, ferritic Cr and austenitic Cr-Ni steels, high manganese steels as well as claddings: for the first layer of chemical resistant weld claddings on ferritic-pearlitic steels up to fine grained structural steels S500N, in steam boiler and pressure boiler construction, as well as creep resistant fine grained structural steels 11NiMoCr4-7 acc. to leaflet "SEW-Werkstoffblatt" No. 365, 366, 20MnMoNi5-5 and G18NiMoCr3-7.

**Typical analysis of the TIG rods (wt.-%)**

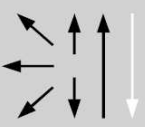
	C	Si	Mn	Cr	Ni
wt-%	0.02	0.5	1.7	24.0	13.0

**Structure:** Austenite with part ferrite

**Mechanische Gütewerte des Schweißgutes**

Heat-treatment	Yield strength R <sub>p0.2</sub>	Yield strength R <sub>p1.0</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V CVN J
	MPa	MPa	MPa	%	+20 °C
aw	430	460	580	30	80

**Operating data**

	<b>Polarity:</b> DC ( - )	<b>Shielding gas:</b> (EN ISO 14175) I1	<b>Marks:</b> ✦ W 23 12 L / ER309L	<b>ø mm</b>	<b>L mm</b>
				1.6	1000
				2.0	1000
				2.4	1000
				3.2	1000

**Approvals**

TÜV (12941), CE