

## AI-0209T

### Specifications

**AS/ANS** 1553.3:ER 309L

**AWS/ASME** A5.4: ER 309L

### Description and Applications

**AI-209T** is suitable for welding steels containing 16-26% Cr and 8-14% Ni.

For welding a wide range of stainless steels to alloy steels. Also ideal for rebuilding worn sections prior to hardfacing.

### Typical Weldmetal Analysis

C	Mn	Cr	Fe	Ni	Si
0.02	1.1	23	Bal	13	0.7

### Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	560MPa
Yield Strength (0.2%)	450Mpa
Elongation	40% (4d)

### Welding instruction

Degrease and clean weld area thoroughly (metallic bright). Preheating and post heat treatment is usually not required.

### Welding Parameters

Diameter (mm)	Current type	Shielding Gas
1.6 x 1000	DC (-)	I 1
2.4 x 1000	DC (-)	I 1
3.2 x 1000	DC (-)	I 1

MIG wire: **AI-1709**

Open arc wire: **AI-1509**

### Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at [sales@alloysint.com.au](mailto:sales@alloysint.com.au)



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