

# TASETO Welding Materials

Bare Stainless Steel Rods

For Gas Tungsten Arc Welding

## TG309L

### ● Applicable Specification

JIS Z 3321 YS309L  
AWS A5.9 ER309L

### ● Identification Color

End Face : Yellowish Green

### ● Applications and Characteristics

TASETO TG309L has the same use as TG309. It is used for welding stainless steel to carbon steel or to low alloy steel. As the carbon content is decreased, it is also suitable for first layer for overlay welding of low carbon stainless steel.

### ● Chemical Composition of Wire (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.015	0.53	1.78	0.009	0.010	13.50	23.51	0.11	0.11

### ● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	4D Elongation (%)
Typical	419	588	39.5

### ● Sizes Available and Recommended Welding Currents (DCEN)

Rod Diameter (mm)	0.8	0.9	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Rod Length (mm)	1000										
Welding Current (A)	50~80		50~120			100~200			150~250		220~280

\*Rod Diameter 0.8, 0.9 mm : Made to order products