

# CORODUR® TS 309 L

CORODUR® TS-309L is a flux cored wire for joining difficult-to-weld steels and for corrosion-proof plating. An austenitic 18/10 type Cr-Ni- weld metal can be obtained already in the first layer. The alloy is also suitable for buffer

layers on plated metal sheets. The highly alloyed weld metal deposited by the wire ensures crack-proof welds and is scale-resistant up to 1000 °C. These deposits are capable of taking high polish.



Joints of 1.4583 mit HI / H II, 17 Mn 4, StE 355.P235GH / P256GH, P295GH, P355N, 1.4825 GX-25CrNiSi18-9 1.4826 GX40CrNiSi22-9 1.4828 X15CrNiSi20-10 1.4832 GX25CrNiSi20-14

## TYPICAL ALL WELD METAL ANALYSIS (%)

C	Si	Mn	Cr	Ni
0,03	0,7	1,4	23,5	13

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{p0,2}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact strength (J)
580	460	35	35 @ -60° C

## FORMS OF DELIVERY

Diameter	Units	Shielding gas
0,9	BS 300	Argon + Co <sub>2</sub>
1,2	BS 300	Argon + Co <sub>2</sub>
1,6	BS 300	Argon + Co <sub>2</sub>

Other dimensions on request

RUST, ACID AND HEAT  
RESISTANT ALLOYS

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