



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 6011

309L Stainless Steel TIG

INTERNATIONAL CLASSIFICATIONS

AWS A5.9 ER309L

BS EN 150 14343-A: 23 12L

DIN 8556: 5GX2CrNi24 12

FEATURES & APPLICATIONS

APPLICATIONS:

Is used for joining stainless steels to carbon or low alloy steels where the corrosion resistance is of secondary importance.

MICROSTRUCTURE:

Austenitic Matrix with a ferrite content of 11 FN according to the Delong diagram

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	P	Si	S	Cr	Ni	Fe
.02	2.0	.012	.40	.01	24	13.5	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength

Maximum Value Up to:

87,000 psi (600 MPa)

Yield Strength

58,000 psi (400 MPa)

Elongation

40%

Impact energy

100 ft lb (136J)

Hardness

Brinell 160, Rockwell B 85

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC- (Argon or helium gas should be used to minimize burn-off of the tungsten electrode).

Recommended Amperage Settings:

Diameter Inches (mm)	Metal Thickness Inches (mm)	Tungsten Size Inches (mm)	Amps	Travel Speed In/Min mm/s	
1/16 (1.6)	1/16 (1.6)	1/16 (1.6)	35-60	12	5.1
3/32 (2.5)	3/32 (2.5)	1/16 (1.6)	45-85	12	5.1
3/32 (2.5)	1/8 (3.2)	1/16 (1.6)	55-100	12	5.1
1/8 (3.2)	3/16 (5.0)	3/32 (2.5)	65-130	10	4.2