

Saffire 23/12-309

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AWS A/SFA 5.9-81 ER309

Description and applications

Saffire 23/12-309 is a nominal 23% chromium, 12% nickel austenitic stainless steel filler rod suitable for TIG welding steels of similar composition. The rod is also ideal for joining dissimilar steel combinations such as mild or low alloy steel to stainless or manganese steel. It may also be used for 'difficult to weld' steels where cold cracking is a danger. Shielding gas is argon or argon/5% hydrogen. Do not use Ar/5%H₂ on steels susceptible to cold cracking.

Composition

Wire Analysis Wt %

	Min	Max
C		0.12
Si	0.30	0.60
Mn	1.0	2.50
P		0.030
S		0.030
Cr	23.0	25.0
Ni	12.0	14.0
Mo		0.50
Cu		0.50