

# Solid Wire Electrode for MIG/MAG Welding

# BA-MIG 309LNb

**Classification:** EN ISO 14343-A: **G 23 12 Nb**  
SFA-5.9: **ER(309LNb)**

## Main Application:

BA-MIG 309LNb is a solid wire electrode for GMAW, niobium-stabilized similar to BA-MIG 309L with the addition of Nb. Suitable for overlay carbon and low-alloy steels, when a type 347 overlay is required.

**Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9:** (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	Nb	P	S	Cu total
Typical analysis BA-MIG 309LNb	0.018	0.35	1.8	0.1	12.5	24.0	0.8	0.020	0.013	0.15
G 23 12 Nb acc. to ISO 14343-A	0.08	1.0	1.0-2.5	0.3	11.0- 14.0	22.0- 25.0	10x%C- 1.0	0.03	0.02	0.3
ER(309LNb) acc. to AWS A5.9	0.03	0.65	1.0-2.5	0.75	12.0- 14.0	23.0- 25.0	10x%C- 1.0	0.03	0.03	0.75

## All - Weld Metal Mechanical Properties / Welding Data:

Heat Treatment	As Welded
Yield Strength Re, N/mm <sup>2</sup> (ksi)	400 (58)
Tensile Strength Rm, N/mm <sup>2</sup> (ksi)	590 (86)
Elongation A5 [%]	>30
Impact Energy ISO-V, J (ft lbs)	+20°C: 100 (74)
Current/polarity	DC +
Shielding Gas	ISO 14175: M13

## Package Forms:

Spools BS300/15 kg, D200/5 kg, and drums as standard package forms for GMAW wire electrodes.

## Diameter:

0,8 – 1,6 mm. Sizes and tolerances acc. to ISO 544 and AWS A5.9.

## Wire Electrode Surface:

Smooth finish free from surface defects and foreign matter.