

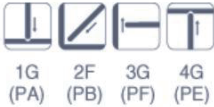
ER309L

AWS A5.9 ER309L

Description:

A super low carbon stainless steel welding wire has high deposition efficiency, used for joining similar 309L alloys or for joining 300-series stainless steels to carbon or low alloy steels, The low carbon content to help prevent intergranular corrosion. Used to weld super low carbon 24%Cr13%Ni and similar stainless steels, like ASTM 309S etc.

Welding Position:



Diameters:

0.8mm,0.9mm,1.0mm,1.2mm.

Typical Mechanical Properties:

Tensile strength(MPa):	625
Yield strength(MPa):	435
Elongation(%):	37

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0,011	1,95	0,012	0,008	0,55	13,8	23,5	0,011	0,010

Welding Current:(DC+)

Diameter(mm)	0,8	0,9	1,0	1,2
Current/A	55-160	65-220	80-240	100-300
Voltage/V	15-24	15-28	15-28	15-29

Note:

- 1.Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
- 2.Shield Gas:Ar+0.5-5%CO₂ or Ar+0.5-3%O₂.
- 3.Gas speed:20-25L/Min
- 4.DC+ connection; Arc length:4-6mm.
- 5. Tig rods ER309L 1.6mm, 2.0mm, 2.4mm, 3.2mm available**