

❖ Product Description

- | | |
|---|--|
| I. Extra low carbon 23Cr/12Ni type steel solid wire | III. The ferrite content ensures highest cracking resistance |
| II. Corrosion and oxidation resistance upto 1100°C | IV. Radiographic weld quality |

❖ Range of Application

- | | |
|--|--|
| I. For welding AISI 309, 309L type steels | III. For buffer layer on low alloy carbon steels |
| II. For dissimilar joints between stainless steels and low alloy and carbon steels | IV. For joining corrosion resistance clad steels |

❖ Classification

- AWS/SFA 5.9 ER309-L

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Cr	Cu	Mo	P	Ni
ER309-L	Min	-	1.0	-	0.30	23.0	-	-	-	12.0
	Max	0.03	2.5	0.03	0.65	25.0	0.75	0.75	0.03	14.0

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
As Welded	520	-	30	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

SHAKUNT ENTERPRISES PRIVATE LIMITED

Corporate Office: - 619/A, EMMAR DIGITAL GREEN, 6th Floor, Sector-61, GURUGRAM (HARYANA)-122102
E-Mail:- info@shakunt.com

Ludhiana Works:- B-XXIX-595/5,Campa Cola Road,Dhandari Kalan Industrial Area-C,Ludhiana (PUNJAB) INDIA

Dharwad Works:- Plot no.577 C & D,Belur Industrial Area,Dharwad-580011 (KARNATAKA) INDIA

Vadodara Works:- 67-A,G.I.D.C,Majusar,Savli,Vadodara-397115 (GUJARAT) INDIA