

## ❖ Product Description

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| <p>I. The wire with extra low carbon concentration designed for welding stainless steel with 23Cr% and 12%Ni.</p> <p>II. Excellent corrosion and oxidation resistance up to 1100°C</p> | <p>III. Ferrite content kept high to ensure highest cracking resistance</p> <p>IV. Radiographic weld quality</p> |
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## ❖ Range of Application

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|---|--|
| <p>I. Suitable for welding AISI 309, 309L type steels</p> <p>II. For dissimilar joints between stainless steel and low alloy or carbon steels</p> | <p>III. For joining corrosion resistance clad steels</p> |
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## ❖ Classification

- AWS/SFA 5.9 ER309-L

## ❖ Chemical Composition

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

## ❖ Wire Size & Weld Diameter

- Diameter in mm-1.6, 2.0, 2.40, 3.20, 4.00 and 5.00.
- All position

## ❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

## ❖ Packaging

|   |                               |          |                 |          |
|---|-------------------------------|----------|-----------------|----------|
| Sizes available in cut length of 1000mm | 1.60,2.00,2.40,3.20,4.00,5.00 |          |                 |          |
| Packing Code                            | A                             |          | B               |          |
| Packing Available                       | 5kg PLASTIC TUBE              | 20KG BOX | 10KG PAPER TUBE | 20KG BOX |
| Net Weight of Wire                      | 5                             | 20       | 10              | 20       |

### Special Note: -

All the value above mentioned are typical values.

- (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.

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