

GETIG 309



IDENTIFICATION : ER 309

SPECIFICATION :AWS A 5.9 ER309

CHARACTERISTICS:

Solid wire deposits a 24 % Cr / 13 % Ni austenitic stainless steel weld metal with a ferrite content about FN 12. The high alloy level and high ferrite content enables the weld metal to tolerate dilution from carbon and low alloy steels without hot cracking. Deposited weld metal is of radiographic quality.

APPLICATIONS :

Buffer layer on mild steel or low alloy steels. Joining of clad steels and dissimilar joints between stainless and mild or low alloy steels. Joining of ferrite - martensitic stainless steels. Welding of similar composition, 309 type stainless steel. Joining type 304/304L, 347, 321, 316/316L and duplex stainless steel to mild and low alloy steels.

SHIELDING GAS : Argon 99.99% 6-12 l/min.

FERRITE CONTENT IN THE WELD METAL : 8 - 16 FN.

WELDING CURRENT : DC (-)

CORROSION RESISTANCE : Good resistance to general and intergranular corrosion. Also good resistance to oxidising acids and cold reducing acids.

COMPOSITION OF THE WIRE (RANGE) %:

C	Mn	Si	Cr	Cu	Ni	Mo	S	P
0.08 max	1.0- 2.50	0.30-0.65	23.0 - 25.0	0.50 max	12-14	0.50 max	0.03 max	0.03 max

MECHANICAL PROPERTIES (RANGE):

Tensile Strength Mpa	Elongation % (L=4D)
550 min	35-45

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	PACKING PER BOX
1.6	1000	5Kg
2.0	1000	5Kg
2.5	1000	5Kg
3.15	1000	5Kg