

M-309

For austenite stainless steel (Dissimilar steels)

Classifications

EN ISO 14343-B:2009	: SS 309	JIS Z 3321:2013	: YS309
AWS A5.9-2012	: ER309	KS D 3696:2006	: STSY309

Description

- MIG welding of 22%Cr-12%Ni STS and dissimilar steels such as 304L to mild steels or low alloy steels.
- A various application of petrochemical and fiber industrial apparatus.

Typical chemical composition of wire (%)

C	Si	Mn	Ni	Cr
0.05	0.42	1.55	13.29	23.12

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)
AWS A5.9		min. 550	min. 25
EN ISO 14343	min. 350	min. 550	min. 30
Example	420	610	40