

FOR STAINLESS STEEL

AWS ER309
JIS Y309

M-309

Typical applications

Welding of similar alloys in wrought or cast forms.

Welding of dissimilar steels, such as 304L to mild steel or low alloy steels.

Typical chemical composition of wire (%)

C	Si	Mn	Ni	Cr
0.05	0.36	1.84	13.30	23.60

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	El (%)	IV (J)
Ar+2%O ₂	610 {62}	40	—

Package

Dia. (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool. (kg)	5, 12.5, 20					
Pailpack.(kg)	200, 250			200, 250, 300		

Approved by BV