

ROYAL –ER 309L (ER 309L)

AWS- SFA A 5.9 ER 309L EN ISO 14343A G/W 23 12 L

Applications

Suitable for welding of dissimilar steel combination such as AISI 304 to carbon manganese steel and carbon steel used in fabrication barrier layer prior to surfacing & clad reparation specially used for root ru.

Characteristics on Usage

This wire rods with low carbon content confirms to AWS –SFA 5.9 ER 309L class. The weld metal is free from porosity with good finish.

Packing

Each Packets content 5 kg of Wire Rods having length 500 mm,1000mm

MIG TIG WIRES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.030Max	1.00 – 2.50	0.30 – 0.65	0.03 Max	0.03 Max	23.0 – 25.0	12.0– 14.0	0.75 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %	Identification Mark
520	30 % Min	Tip color Green