

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 <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)	IV (J)
Ar+2%O <sub>2</sub>	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