

# SUNMIG 309L

Low Carbon Austenitic Stainless Steel Solid Welding Wire



## CLASSIFICATION

AWS/SFA 5.9 : ER309L

## CHARACTERISTICS

SUNMIG 309L is a solid welding wire available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. It typically contains 24% Cr and 12% Ni, is used for the welding of type 309, 309L as well as dissimilar combination of steels. The low carbon (0.03% max) in weld metal increases the resistance to intergranular corrosion/cracking.

## APPLICATIONS

SUNMIG 309L welding wire is ideally suited for welding of AISI 309, 309L type steels. Also find its application in dissimilar joints between stainless steels and low alloy or carbon steels, welding clad side of Type 304, 304L clad steels, buffer layer on low alloy or carbon steels.

## SPECIFIED CHEMICAL COMPOSITION OF BARE SOLID WIRE (%):

C	Mn	Si	Cr	Ni	Mo	S	P
0.03 max	1.0-2.5	0.30-0.65	23.0-25.0	12.0-14.0	0.75 max	0.03 max	0.03 max

## SPECIFIED MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength (N/mm <sup>2</sup> )	Elongation (%) GL=5d
520.0 min	30.0 min

Mechanical properties will vary with the type of shielding gas used.

## PACKING DATA:

Diameter (mm)	KG/spool
0.80	12.5 Kg
1.20	12.5 Kg
1.60	12.5 Kg
2.00	12.5 Kg

**SHIELDING GAS :** 98% Argon – 2%O<sub>2</sub> or Argon-1%-5% CO<sub>2</sub>

**GAS FLOW** : 15-22 L/min

**CURRENT** : DCEP