

Supershield 309L-0

Conformances

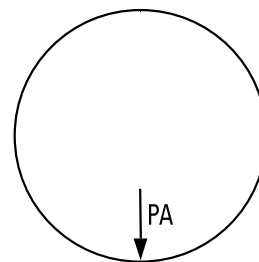
Applications

- Crusher rolls and hammers, cone mills

Features

- Open arc type hardfacing wire(buffer layer)
- High-Cr/Ni stainless steel type

Welding Position



Current

DC +

Welding Process

Open Arc

Diameter / Packaging

Diameter	Coil	Pac	
mm (in)	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)
2.8 (7/64)	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	Cr	Ni	Mo
As welded with 2.8mm wire	0.02	0.35	1.4	22.5	12.5	0.05

Typical Mechanical Properties of All-Weld Metal

	Rockwell Hardness (HRc)	TS MPa(lbs/in ²)	EL (%)
All-Weld Metal	-	630 (91,400)	38

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
2.8mm (7/64in), DC+					
Open Arc	25 (1)	2.9 (114)	330	27	5.1 (11.2)
		3.3 (130)	360	29	5.8 (12.7)
		3.8 (149)	400	30	6.7 (14.7)