

ST-309

22%Cr-12%Ni steel, 18%Cr-8%Ni clad steel, STS-CrMo, STS-Carbon steel



Conformances

AWS A5.9/ ASME SFA5.9 ER309
 JIS Z3321 YS309
 EN ISO 14343-A W 23 12
 ABS AWS A5.9 ER309
 CE

Applications

- Steel Structures - Oil, Textile industries, Nuclear reactor

Features

- Resistance to crack
- High Efficiency
- Excellent resistance to heat

Current

DC -

Shielding Gas

Ar

Diameter / Packaging

Diameter	
mm (in)	5kg*1000
1.0 (0.039)	
1.2 (0.045)	
1.6 (1/16)	✓
2.0 (5/64)	✓
2.4 (3/32)	✓
2.6 (0.10)	✓
3.2 (1/8)	✓

Typical Chemical Composition of the Wire(%)

C	Si	Mn	Cr	Ni
0.07	0.38	1.88	24.4	12.8

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
620 (90,000)	38	0 (32)	130 (96)

SMW

SAW

GMW

GTAW

FCW

Non-FERROUS

APPENDIX