

ROYAL –ER 309 (ER 309)

AWS- SFA A 5.9 ER 309

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 restoration specially used for root run.

Characteristics on Usage

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

Chemical Composition Of Weld Metal

| C% | Mn% | Si% | S% | P% | Cr % | Ni % | Mo |
|---------|-------------|-------------|----------|----------|-------------|------------|------|
| 0.12Max | 1.00 – 2.50 | 0.30 – 0.65 | 0.03 Max | 0.03 Max | 23.0 – 25.0 | 12.0– 14.0 | 0.75 |

Mechanical Properties Of Weld Metal

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

Packing

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