

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