

SUBARC 309L



Mainly used under high dilution conditions, particularly dissimilar welds between stainless and CMn steels. There are 3 main areas of application: Buffer layers and clad steels, Dissimilar joints and Similar metal joints.

MATERIALS TO BE WELDED

There are three main areas of application : Buffer layers and clad steels. Dissimilar joints and Hardenable steels.

CLASSIFICATIONS

AWS A5.9 ER309L

CHEMICAL ANALYSIS

% Carbon	0.015	% Chromium	23.00
% Manganese	1.700	% Nickel	13.00
% Silicon	0.500	% Molybdenum	0.100
% Sulphur	0.005	% Copper	0.150
% Phosphorus	0.015	% Ferrite	12.00

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

Tensile Strength	600 MPa
0.2% Proof Stress	400 MPa
Elongation on 4d	40%
Impact Energy -50°C	100J

* Flux Dependant

PACKING DATA

SAW Wire (DC+)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
2.40	350	29	078-152	25
3.20	400	32	078-154	25

Suggested flux : Afrox Flux MH or DX-9

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