MG-S309 PREMIARC™

Solid wire

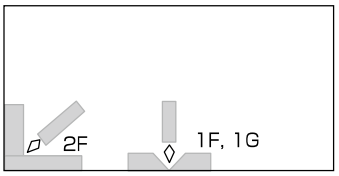
Features:
- Suitable for dissimilar-metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals

Classification: AWS A5.9 ER309

Shielding gas: Ar-2%O_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	
0.9	10kg	-
1.0	10kg	20kg
1.2	10kg	20kg
Volume mm	240W, 110H, 240L	285W, 110H, 285L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.05	0.12
Si	0.46	0.30~0.65
Mn	2.0	1.0~2.5
P	0.02	0.03
S	<0.01	0.03
Ni	13.7	12.0~14.0
Cr	23.3	23.0~25.0
Mo	0.03	0.75
Cu	0.03	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F
0.9	70~200
1.0	80~250
1.2	100~300

All-weld mechanical properties

	Typical
0.2%YS (MPa)	430
TS (MPa)	610
El on 4d (%)	39