MG-S309LS PREMIARC™

Solid wire

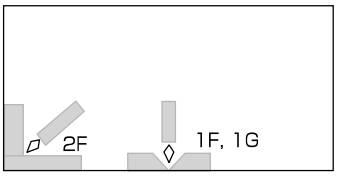
Features:
- Suitable for dissimilar-metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals

Classification: AWS A5.9 ER309LSi

Shielding gas: Ar-2%O_2

Polarity: DCEP

Welding Positions:



Packaging data

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

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.02	0.03
Si	0.84	0.65~1.00
Mn	1.8	1.0~2.5
P	0.02	0.03
S	<0.01	0.03
Ni	13.3	12.0~14.0
Cr	23.6	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
1.2	100~300

All-weld mechanical properties

	Typical
0.2%YS (MPa)	410
TS (MPa)	570
El on 4d (%)	40
IV 0℃ (J)	88