

FOR STAINLESS STEEL

AWS ER309L
JIS Y309L

M-309L

Typical applications

Welding of similar alloys in wrought or cast forms and clad side of type 304L clad steels. The low ferrite content improves the crack-resistance and corrosion-resistance.

Typical chemical composition of wire (%)

C	Si	Mn	Ni	Cr
0.01	0.40	1.92	13.80	23.20

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	EI (%)	IV (J)
Ar+2%O ₂	570 {58}	42	0°C: 100

Package

Dia. (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool. (kg)	5, 12.5, 20					
Pailpack.(kg)	200, 250			200, 250, 300		

Approved by