



S. R. Industries

STAR ARC ER309/309L

ER309/309L is very similar to type 309 except for the carbon content being lower than .03%. The extra low carbon content provides good resistance to carbide precipitation and intergranular corrosion. ER309L works well for dissimilar joints that undergo heat treatment.

AWS Specification : AWS A5.9/A5.9M:2006

AWS Classification	ER309
	ER309L
Welding Current	DCEP
Typical Wire Chemistry	
C	0.12
Cr	23.0 - 25.0
Ni	12.0 - 14.0
Mo	0.75
Mn	1.0 - 2.5
Si	0.30 - 0.65
P	0.03
S	0.03
Cu	0.75
Typical Mechanical Properties (As Welded)	
Yield Strength, ksi	58

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<i>Tensile Strength, ksi</i>	85
<i>Elongation%, min</i>	36
<i>Welding Positions</i>	<i>F,V,OH,H</i>
<i>Available Diameters MIG with Operating Range in Amps</i>	
<i>.023"</i>	<i>35 - 70</i>
<i>.030"</i>	<i>50 - 100</i>
<i>.035"</i>	<i>160 - 210</i>
<i>.045"</i>	<i>180 - 250</i>
<i>Available Diameters TIG with Operating Range in Amps</i>	
<i>.035"</i>	<i>60 - 90</i>
<i>.045"</i>	<i>80 - 110</i>
<i>1/16"</i>	<i>90 - 130</i>
<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>
<i>5/32"</i>	<i>170 - 350</i>

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