

Gas Metal Arc Welding

JIS Z3321 Y309
AWS A5.9 ER309
DIN 8556-SG 1.4829

MS M-309 Solid Wires for Stainless Steel

Applications Suitable for dissimilar-metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals, such as joining type 304 to carbon steel.

Brand Name		MS M-309								
Representative of diameter (mm)		0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo		
	≤ 0.12	≤ 0.65	1.0 - 2.5	≤ 0.03	≤ 0.03	12.0 - 14.0	23.0 - 25.0	-	-	
Mechanical property of deposited metal										
Tensile strength	≥ 550 N/mm ²									
0.2% Offset strength	≥ 225 N/mm ²									
Elongation	≥ 35 %									
Impact test	NA									
Welding position	Horizontal/Flat position									
Welding polarity	DC-EP									
Shielding gas	98%Ar - 2%O ₂									
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm					
	80-180A	120-200A	140-250 A	170-300 A	200-350A					
Packing	12.50 kgs standard other packing weight can be provided upon request.									