

# Gas Tungsten Arc Welding

## MS T-309 Filler Rod 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 T-309								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0	
Chemical composition of length	1000 mm Standard or 950 mm Upon requested.									
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	≥ 540 N/mm <sup>2</sup>									
0.2% Offset strength	≥ 225 N/mm <sup>2</sup>									
Elongation	≥ 30 %									
Impact test	NA									
Welding position	All position									
Welding polarity	DC-EN									
Shielding gas	Ar									
Welding current	Dia. 1.2 mm		Dia. 1.6 mm			Dia. 2.4 mm				
	30-80 A		40-120 A			50-150 A				
Packing										
Inner case weight (kg)	5.00									