

PermaWeld

AWS ER-309L

DESCRIPTION:

Similar at ER-309, but the 0.03% maximum carbon content increases resistance to intergranular corrosion. Used for welding similar alloys in wrought or cast form. Occasionally used for welding 18-8 base metals when severe corrosion conditions exist, and, at times, welding dissimilar steels.

APPLICATIONS:

Welding with different materials, good heat and corrosion resistance, welding of low carbon stainless steel and low carbon clad steel and SUS309S, heat resistance steel 13Cr, 18Cr or dissimilar steel

CHEMICAL COMPOSITION OF DEPOSITED WIRE

	C	Cr	Ni	Mo	Mn	Si	P	S
Typical	0.03	23.0-25.0	12.0-14.0	0.75	1.0-2.55	0.30-0.65	0.03	0.03

WELD METAL PROPERTIES

	Tensile Strength (psi)	Yield Strength (psi)	Elongation
Typical	≥ 500 MPa	≥ 420 MPa	≥ 22 %