

# Nouvarc ER309L

## AWS SFA 5.9 ER309L

### Characteristics & Application

Solid rod for joining of stainless steels (309, 309L, etc. Well adapted for welding of dissimilar steels.

Its high ferrite content allows for greater dilution without risk of cracking.

Also suitable for welding high temperature steels and as buffer layer before Hardfacing.

### Welding Positions

All

### Typical End Chemistry

C%	Mn%	Si%	Cr%	Ni%	S%	P%	Mo%
0.015	1.80	0.40	23.20	13.80	0.01 max	0.02 max	0.10

### Mechanical Properties

UTS N/mm <sup>2</sup>	YS N/mm <sup>2</sup>	ELONG %
620 min	420 min	35 min

[Values obtained with good operating conditions]

### Shielding Gas

100% Ar (6-12 lpm)

### Packing Particulars

Diameter of Wire : In mm 0.80 | 1.0 | 1.20 | 1.60 | 2.00

### Packing Norms

Plastic Spools and Drum Pack in  
12.5 Kg | 15 Kg | 100 Kg | 250 Kg