

## Filler rod and wire

<b>Features:</b>	▪ Suitable for dissimilar-metal joint and underlaying on ferritic steels
<b>Classification:</b>	AWS A5.9 ER309L
<b>Shielding gas:</b>	Ar
<b>Identification color:</b>	1st Yellow green
<b>Polarity:</b>	DCEN

## Packaging data

φ mm	Spool		Tube	
	kg	kg	Length mm	g/piece
0.9	10	-	-	-
1.2	10	5	1,000	9
1.6	10	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
3.2	-	5	1,000	64
<b>Volume mm</b>	240W, 110H, 240L		40W, 35H, 1015L	

## Composition (rod and wire mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.01	0.03
<b>Si</b>	0.42	0.30~0.65
<b>Mn</b>	1.7	1.0~2.5
<b>P</b>	0.02	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	13.5	12.0~14.0
<b>Cr</b>	23.3	23.0~25.0
<b>Mo</b>	0.04	0.75
<b>Cu</b>	0.05	0.75

Note: <sup>a</sup> Single values are maximum.

## Welding parameters (A)

φ mm	
0.9	50~80
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250
3.2	200~300

## All-weld mechanical properties

	Typical
<b>0.2%YS (MPa)</b>	410
<b>TS (MPa)</b>	570
<b>El on 4d (%)</b>	38
<b>IV 0°C (J)</b>	110

## Approvals

<b>LR</b>	SS/CMn m (Chem & Cryo)
<b>NK</b>	KY309L