

Filler rod and wire

Features:	▪ Suitable for dissimilar-metal joint and underlaying on ferritic steels
Classification:	AWS A5.9 ER309
Shielding gas:	Ar
Identification color:	1st Black
Polarity:	DCEN

Packaging data

φ mm	Spool		Tube	
	kg	kg	Length mm	g/piece
1.0	10	5	1,000	6
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
Volume mm	240W, 110H, 240L		40W, 35H, 1015L	

Composition (rod and wire mass%)

	Typical	Guaranty ^a
C	0.05	0.12
Si	0.47	0.30~0.65
Mn	1.6	1.0~2.5
P	0.02	0.03
S	<0.01	0.03
Ni	13.6	12.0~14.0
Cr	23.1	23.0~25.0
Mo	0.10	0.75
Cu	0.12	0.75

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	
1.0	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
0.2%YS (MPa)	410
TS (MPa)	580
EI on 4d (%)	39
IV 0°C (J)	150

Approvals

DNV	NV309
NK	KY309
GL	4332