
 <p>Complete Welding Support</p>	Autotherme Grade-309L (SAW Wire)	
	An extra low carbon 24 % Cr & 13 % Ni Stainless steel wire for SAW	

CLASSIFICATION: **AWS: SFA 5.9**
ER309L

CHARACTERISTICS & APPLICATIONS:

Autotherme Grade 309L wire is suitable for welding of 24 % Cr – 13%Ni. Stainless steel wire for SAW. Low carbon grade (0.03 % max) of this wire is also available. The filler metals are used for both joining similar metals or joining of dissimilar metals like; mild steel/ low alloy steel with 302/304 grade stainless steel. also suitable for cladding applications.

CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:

Element	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Typical	0.028	1.70	0.38	0.011	0.025	23.95	12.15	0.065	0.17
Range	0.03 Max	1.0 - 2.5	0.30- 0.65	0.03 Max	0.03 Max	23.0- 25.0	12.0- 14.0	0.75 Max	0.75 Max

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, WT. %:

MAXFLUX	Element	C	Mn	Si	S	P	Cr	Ni	Cu
SS4	Typical	0.05	1.50	0.35	0.012	0.025	24.0	12.5	0.30

MECHANICAL PROPERTIES OF WELD METAL:

MAXFLUX	Property	UTS (MPa)	EI (L=4d) (%)
SS4	Typical	590.0	35.0

PACKING:	STANDARD SIZE	Diameter 2.5mm, 3.2mm & 4.0 mm
	QUANTITY	<ul style="list-style-type: none"> ➤ 25 kg. Wire in metallic ring. ➤ Identification-Brand name & size is printed on label. ➤ Packed in corrugated cardboard box.

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