

**ROYAL –ER 309 (ER 309)**

AWS- SFA A 5.9 ER 309

**Applications**

Suitable for welding of dissimilar steel combination such as AISI 304 to carbon manganese steel and carbon steel used in fabrication barrier layer prior to surfacing & clad restoration specially used for root run.

**Characteristics on Usage**

This wire rods confirms to AWS – SFA 5.9 ER 309 class. The weld metal is free from porosity with good finish.

**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.12Max	1.00 – 2.50	0.30 – 0.65	0.03 Max	0.03 Max	23.0 – 25.0	12.0– 14.0	0.75

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	Identification Mark
520	30	Tip color Green

**Packing**

Each Packets content 5 kg of Wire Rods having length 500 mm,1000mm