

FOR STAINLESS STEEL

**AWS ER309L**  
**JIS Y309L**

**M-309L**

**Typical applications**

Welding of similar alloys in wrought or cast forms and clad side of type 304L clad steels. The low ferrite content improves the crack-resistance and corrosion-resistance.

**Typical chemical composition of wire (%)**

C	Si	Mn	Ni	Cr
0.01	0.40	1.92	13.80	23.20

**Typical mechanical properties of all-weld-metal**

Shielding Gas	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)	IV (J)
Ar+2%O <sub>2</sub>	570 {58}	42	0°C: 100

**Package**

Dia. (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool. (kg)	5, 12.5, 20					
Pailpack.(kg)	200, 250			200, 250, 300		

Approved by