

Supershield 309L-O

Features

- Open arc type hardfacing FCAW (buffer layer)
- High Cr/Ni stainless steel type

Polarity

DC +

Application Areas

- Welding of dissimilar metals, cladding

Shielding Gas

None

Typical Chemical Composition of All-Weld Metal (wt%)

Wire size	C	Si	Mn	Ni	Cr	Mo
2.8(7/64)	0.02	0.3	1.2	12.5	22.5	0.04

Typical Mechanical Properties of All-Weld Metal

HRC (≥4Layers)
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Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)
2.8 (7/64)	350~450

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Packaging
2.4 (3/32)	Coil 25kg(55lbs), Drum 150kg, 250kg
2.8 (7/64)	

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux