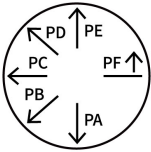
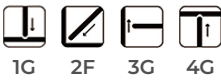


SM-309L

Classification

AWS A5.9/ASME SFA-5.9 ER309L
JIS Z 3321 YS309L
EN ISO 14343-A-G 23 12L

Welding Positions



Features

- Resistance to crack
- High Efficiency
- Excellent resistance to heat

Polarity

DC +

Application Areas

- Steel structures
- Vehicles, machinery and bridges

Shielding Gas

Ar + 2% O2

Approvals

CE
✓

Typical Chemical Composition of the Wire (wt%)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo
0.02	0.46	1.6	0.02	0.01	0.07	13.7	23.2	0.12

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
Ar + 2% O2	565 (82)	45	-60 (-75)	100 (74)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Packaging
0.9 (0.035), 1.0 (0.039), 1.2 (0.045), 1.4 (0.052), 1.6 (1/16)	Spool 12.5kg(28lbs) Drum 250kg (551lbs)

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux