

# Stainless Steel SMAW Electrodes

## G309

AWS A5.4 E309-16  
JIS Z 3221 ES309-16

### Product Features:

- All deposited weld metal contains approximately 23%Cr-13%Ni elements stainless steel covered electrode.
- Austenite weld metal contains adequate ferrite numbers to get very low crack sensitivity.
- Good heat and corrosion resistance.

### Applications:

- Welding of SUS 309S stainless steel.
- Welding of Carbon steel or other high hardening alloy steels to stainless steel.
- Cladding or welding of stainless steel to carbon steel or low alloy steel.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Fe
0.04	0.83	1.04	13.25	23.83	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %
543	616	36

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	60~85	85~120	115~150	150~200
Vertical / overhead position	50~70	75~105	95~120	----

### Note:



Goodweld Corporation  
No.99, Huangong Rd. Yongkang Tainan, Taiwan  
Phone: 886-6-2331003 Fax: 886-6-2333213  
All Right Reserved