

Stainless Steel MIG•TIG Wire/Rod

GM309 / GT309

AWS A5.9 ER309
JIS Z 3321 YS309
ISO 14343-A-G 22 12 H
14343-A-W 22 12 H

Product Features:

- Austenite weld metal contains adequate ferrite numbers to provide 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.

Shielding gas:

- Ar+ 1~2% O₂ (MIG)
- 100%Ar (TIG)

Typical chemical composition of wire / rod (wt%)

C	Si	Mn	Ni	Cr	Fe
0.05	0.45	1.60	13.7	23.10	Bal.

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
600	43

MIG Size (mm) & recommended welding parameters; DC+

Diameter (mm)	0.9/1.0	1.2	1.6
Current range (Amp)	70~200	90~250	200~300

TIG rod size diameter/length; DC-

Diameter (mm)	1.6	2.0	2.4/2.6	3.2
Length (mm)	1000	1000	1000	1000

Note:

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