

Product Data Sheet



BRAND NAME VJ ER309

AWS/ASME Class ER309

SPECIFICATION SFA A5.9

Features and Applications :

VJ ER309 is a solid wire with a bright finish, ensuring smooth flow, a stable arc, and spatter-free welding. It provides radiographic-quality weld deposits and is ideal for welding stainless steels, wrought and cast materials, 18/8 stainless to carbon steels, and 18/8 clad stainless steels.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.06	Mn	1.80
Cr	23.50	Si	0.40
Ni	13.0	S	0.015
Mo	0.25	P	0.018
Cu	0.20		

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	580
El (%)	34

DIMENSIONS:

Dimension (mm)	
GMAW	GTAW
0.80	1.6
1.20	2.0
1.60	2.4
	3.2

GMAW CURRENT : DC (+)	SHIELDING GAS: ARGON
GTAW CURRENT : DCEN	SHIELDING GAS: ARGON

PACKING :

GTAW : 5 kg wire put in a plastic container. Identification AWS code is punched on side of wire.

GMAW : The wire can be supplied in plastic spool packed in a cardboard box weighing 15.0 kg.

WELDING POSITION:

