

# Product Data Sheet



**BRAND NAME** VJ ER309L

**AWS/ASME Class** ER309L

**SPECIFICATION** SFA A5.9

## Features and Applications :

VJ ER309L is a solid wire for MIG& TIG welding, available same superior qualities as ER309 but with a lower carbon content, making it ideal for chemical applications requiring enhanced corrosion resistance. It is preferred for cladding over carbon or low-alloy steels and for dissimilar joints that are heat treated.

## CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.03	Mn	1.0-2.5
Cr	23.0-25.0	Si	0.30-0.65
Ni	12.0-14.0	S	0.030
Mo	0.75	P	0.030
Cu	0.75		

## MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	560
El (%)	34

## DIMENSIONS:

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

<b>GMAW CURRENT</b> : DC (+)	<b>SHIELDING GAS:</b> ARGON
<b>GTAW CURRENT</b> : DCEN	<b>SHIELDING GAS:</b> 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:

