

Select 309/309L (GTAW)

Stainless Steel / Gas Shielded / TIG (GTAW)

PRODUCT DATA SHEET

FEATURES

- Low carbon (C), < 0.03 wt%, minimizes carbide precipitation (sensitization) which makes the weld metal more resistant to intergranular corrosion.
- Actual chemistry certificate with calculated ferrite number (FN) available for each lot.
- Embossed identification markings on both ends of the electrode.
- Applications for this alloy type include welding dissimilar metal, such as type 304 SS to mild steel, cladding mild steel or type 304 base metals where corrosion requires to be enhanced, and welding of the stainless steel side of type 304 claddings.

CONFORMANCES

AWS A5.9

ER309

ER309L

ASME SFA 5.9

ER309

ER309L

DIAMETERS (in [mm])

1/16 (1.6), 3/32 (2.4), 1/8 (3.2), 5/32 (4.0)

POSITIONS



SHIELDING GAS

100% Argon

Flow Rate: 10 - 35 CFH

POLARITY

Direct Current Electrode Negative (DCEN)

TYPICAL WIRE CHEMISTRY (WT%)

Shielding Gas	C	Cr	Cu	Mn	Mo	Ni	P	S	Si
N/A	0.02	23.5	0.17	2.20	0.06	13.7	0.02	0.01	0.40

PACKAGING (lbs [kgs])

10 (4.5) Tube, 40 (18.1) Master Carton

**Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.*

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.



Revision: 4/17/2024

Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

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