

# KT-309L

## Classification

AWS A5.9/A5.9M

ER309L

## Applications and Features

- ( 1 ) Weld metal is austenite structure with low carbon 24%Cr-13%Ni.
- ( 2 ) Superior crack and corrosion resistance due to moderate ferrite content.
- ( 3 ) Ideal for welding dissimilar metals (carbon steel to stainless steel).

## Typical Chemical Composition (wt%)

C	Si	Mn	P	S	Cr	Ni
0.022	0.39	1.94	0.009	0.011	23.84	12.92

## Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar)

Tensile Strength MPa	Yield Strength MPa	Elongation %
580	410	41

## Sizes and Suggested Operating Range

Size mm	Current A	Gas Flow L/min	Shielding Gas
1.6	75- 100	25	Ar
2.4	150-200	25	Ar

Diam.	5 kg Tube
1.6mm	KT30916
2.4mm	KT30924

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