

## DESCRIPTION

Executive ER309/309L wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive ER309/309L is the best choice for dissimilar welding of stainless to carbon or low alloy steels.

## APPLICATIONS & FEATURES

Executive ER309/309L is used in the automotive industry, pressure piping, vessel manufacturing, cladding, and general manufacturing and fabrication.

Executive ER309/309L has a maximum carbon level of 0.03% which enhances the resistance to intergranular corrosion.

## TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N	
0.019	23.60	12.25	0.040	1.76	0.39	0.020	0.008	0.18	0.018	
<b>Tensile Strength:</b>		85,600 PSI min						<b>Elongation:</b>		40%
<b>Yield Strength:</b>		58,000 PSI min								

## TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
<b>GMAW</b> - Short	.035"	21-22	160-200	30 to 50 CFH	98% Ar / 2% O <sub>2</sub>	
	.045"	22-23	180-210			
	- Spray	.035"	23-25		190-260	90% Ar / 10% O <sub>2</sub>
		.045"	25-28		250-330	
<b>GTAW</b>	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	
<b>SAW</b>	.093"	29-32	300-350		Record IN Flux	
	.125"	29-32	400-550			

## STANDARD PACKAGING

<b>GMAW</b> (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
<b>GTAW</b> (TIG)	10-lb plastic tube	40-lb box
<b>SAW</b>	60-lb wire coil	1,200-lb pallet

## CLASSIFICATION

AWS/SFA 5.9, Class **ER309/309L**  
Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.

