



FW 309

CODIFICATION: AWS : SFA 5.9 ER309

CHARACTERISTICS AND APPLICATIONS:

FW 309 is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. The weld metal has excellent mechanical properties and possesses good oxidation and scaling resistance at elevated temperatures. It is ideally suited for welding stainless steels, wrought and cast materials of similar composition, welding of 18/8 type stainless steels to carbon steels for buffer layers, for welding clad side of 18/8 clad stainless steels, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Ni
%	0.05	1.75	0.35	0.010	0.020	23.3	13.8

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 4d) %
570	32.0

SHIELDING GAS: Argon

CURRENT CONDITIONS: DCEN

WELDING POSITIONS: H, F, VU, OH

PACKING:

STANDARD SIZE: Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 1000 mm each.

QUANTITY 5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container.
Identification – AWS code is punched on each wire.