

# Inweld

Alloy ER309

AWS A5.9



## Description and Applications:

ER309 is used to weld alloy 309. Occasionally, it is used to weld Type 304 and similar base metals where severe corrosion conditions exist requiring higher alloy weld metal. It is also used in dissimilar metal welds, such as joining Type 304 to carbon steel, welding the clad side of Type 304 clad steels, and applying stainless steel sheet linings to carbon steel shells.

## Chemical Composition of ER309

C	Cr	Cu	Mn	Mo	Ni	P	S	Si
0.12	23.0-25.0	0.75	1.0-2.5	0.75	12.0-14.0	0.03	0.03	0.30-0.65

Single values are maximum unless otherwise specified.

