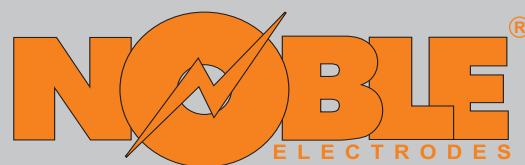


NOBLE - ER309L

Stainless Steel MIG Wire



CLASSIFICATION

AWS - A5.9 : ER309L

Characteristics : **NOBLE - ER309L**(MIG wire) is low carbon stainless steel MIG wire, the weld metal contains ferrite and its resistance to crack is extremely good. Due to its high level of alloy, it has excellent resistance to heat.

Applications : **NOBLE - ER309L**(MIG wire) is suitable for the joining ferrite to austenite stainless steel for services temperature up to 300°C. Heat resisting cast steel clad side 18% Cr-8% Ni clad steel and stainless steel to Cr-M steel or carbon steel.

Chemistry of Wire (%)

Elements	C	Cr	Ni	Mo	Mn	Si	P	S	Cu
Range	0.03 Max	23-25	12-14	0.75 Max	1.00- 2.50	0.30- 0.65	0.03 Max	0.03 Max	0.75 Max

Shielding gas: 100% Ar or Ar+ 2%O₂

Operating conditions & Packing Specifications

Size (mm)	Current (Amp.) DC (+)	Voltage (V)	Spool Packing
0.80	70 - 220	16 - 24	12.500 Kg.
1.20	150 - 300	24 - 34	12.500 Kg.
1.60	150 - 350	28 - 36	12.500 Kg.

“Noble – Characterized by all Excellent Qualities”