CWR-309LHS Welding Wire and Rod

CWR-309LHS has the same chemical composition as CWR-309L with higher silicon content to provide better arc stability and improve bead appearance. CWR-309LHS is suitable for joining stainless steel type 304, 321 and 347. It is also widely used for cladding over carbon or low alloy steels.

CONFORMANCES

AWS A5.9/A5.9M : ER 309LSi
ASME SFA-A5.9 : ER 309LSi

AWS CHEMICAL COMPOSITION *(TYPICAL)*

%C	%Cr	%Ni	%Mo	%Mn
0.03 max	23.0 – 25.0	12.0 – 14.0	0.75 max	1.0 – 2.5
0.015	*23.3*	*13.8*	*0.08*	*1.9*

%Si	%P	%S	%Cu	Total Others
0.65 – 1.00	0.03 max	0.03 max	0.75 max	0.50 max
0.83	*0.02*	*0.01*	*0.06*	

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength : 60,000 psi
Tensile Strength : 87,000 psi
Elongation : 35 %

TYPICAL WELDING PARAMETERS

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16”	1.6 mm	14 – 17	90 – 130	100% Ar
	3/32”	2.4 mm	15 – 20	120 – 175	100% Ar
	1/8”	3.2 mm	16 – 20	200 – 330	100% Ar
MIG (GMAW)	.035”	0.9 mm	26 – 31	150 – 230	98%Ar – 2%O_2
	.045”	1.1 mm	28 – 32	180 – 280	98%Ar – 2%O_2
Sub Arc (SAW)	.093”	2.4 mm	28 – 32	300 – 400	
	.125”	3.2 mm	29 – 32	400 – 550	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED
BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

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