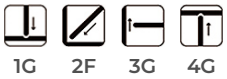
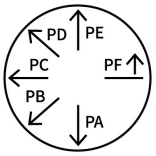
SW-309HBF

Classification

AWS AWS A5.22/ ASME SFA-5.22 E309(H)T1-1/4
JIS Z 3323 TS309H-BiF-FB1
EN 17633-B T 309H F M21/C1 2

Welding Positions





Features

- Designed for welding with 100% CO2 or Ar+15~25% CO2 shielding gas
- Excellent all position weldability
- Smooth and stable arc with a fast freezing slag

Polarity

DC +

Application Areas

- Welding of dissimilar metals such as stainless steel and carbon steel or stainless steel and low alloy

Shielding Gas

100% CO2
Ar+15~25% CO2

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	Bi
100% CO2	0.06	0.8	1.5	0.014	0.009	0.01	12.3	22.8	0.01	5ppm
Ar+20% CO2	0.06	0.8	1.5	0.015	0.008	0.01	12.2	22.7	0.01	5ppm

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	570 (83)	40	-20 (0) -60 (-75)	55 (41) 50 (37)
Ar+20% CO2	574 (83)	43	-20 (0) -60 (-75)	58 (43) 54 (40)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	160~220	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)
1.6 (1/16)	250~290	