

Supershield 309L-0

AUSTENITIC STS TYPE OPEN ARC WIRE

HYUNDAI WELDING CO., LTD.



Supershield 309L-O

❖ Specification

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❖ Description & Applications

Supershield 309L-O is an open arc type wire. Cr, Ni alloy, diluting base steels to obtain deposited metal such as 304, 304L.

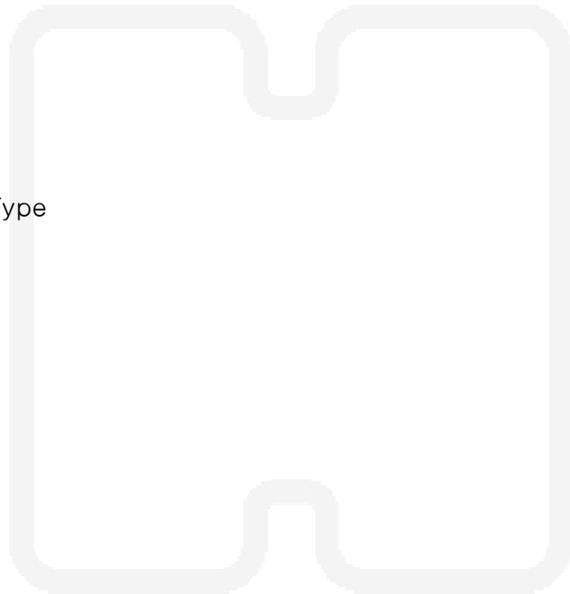
(Welding of dissimilar metals, Cladding)

❖ Welding Process

Open Arc Type

❖ Current Type

DC+



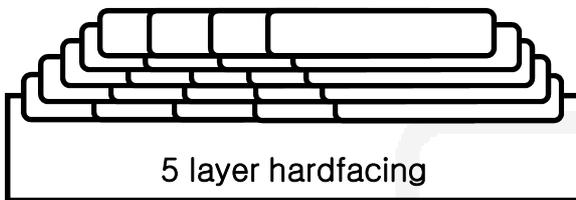
❖ Packing

Supershield 309L-O	Dia.	2.8mm(7/64in)
	Coil	25kg(55lbs)
	Pailpack	150kg(330lbs), 250kg(551lbs)



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



Diameter	: 2.8mm(7/64in)
Welding Type	: Open Arc
Amp./ Volt.	: 380 / 29
Stick-Out	: 25~30mm(0.98~1.18in)
Pre-Heat	: 150~250℃(302~482°F)
Interpass Temp.	: 200~300℃(392~572°F)
Total layers	: ≥4 layer

❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	Cr	Ni	Mo
Supershield 309L-O	0.02	0.35	1.40	22.5	12.5	0.05

❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
Supershield 309L-O	8	8	8	9	9	8.5



Test Results

❖ BEAD APPEARANCE

Consumable	Supershield 309L-O
Amp.(A)	370~390
Volt.(V)	27~29
Carrige Speed	40~60cm/min(15.7~23.6in/min)
Welding Position	Flat(1G)



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