

# TASETO Welding Materials

Bare Stainless Steel Rods

For Gas Tungsten Arc Welding

## TG309

### ● Applicable Specification

JIS Z 3321 YS309  
AWS A5.9 ER309

### ● Identification Color

End Face : Black

### ● Applications and Characteristics

TASETO TG309 is the welding material with the chemical composition of 25%Cr-12%Ni. As the contents of Cr and Ni are increased compared with Type 308 stainless steel, it is suitable for welding of dissimilar metals such as stainless steel to carbon steel or to low alloy steel.

### ● Chemical Composition of Wire (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.042	0.41	1.62	0.011	0.010	13.24	24.35	0.11	0.15

### ● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	4D Elongation (%)
Typical	430	598	38.6

### ● Sizes Available and Recommended Welding Currents (DCEN)

Rod Diameter (mm)	0.8	0.9	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Rod Length (mm)	1000										
Welding Current (A)	50~80		50~120			100~200			150~250		220~280

\*Rod Diameter 0.8, 0.9 mm : Made to order products