

# Satin Glide® 309L Stainless-Steel Welding Wire



Satin Glide® 309L Stainless-Steel Welding Wire is a filler metal that features composition and metallurgical properties that ensure excellent compatibility with a variety of base metals.

Formulated with a high content of chromium and nickel, this welding wire provides greater protection against rust, oxidation, and corrosive environments. Its lower carbon content makes it suitable for welding applications where reduced carbon precipitation is desired to prevent sensitization and intergranular corrosion.

## Manufacturing Advantages

- All metal transfer modes of GMAW
- Robotic, mechanized, or semi-automatic welding
- Single and multi-pass weldments
- Dissimilar base metal welding
- Compatible with various austenitic stainless-steel base metals
- Lower carbon content to reduce risk of carbide precipitation and sensitization
- Suitable for high-temperature corrosion resistant applications

## Welding Positions

All position welding is possible when using the correct shielding gas blends, welding process, and welding parameters.

## Shielding Gas Blends

- Short Circuit Transfer: 90% Helium, 7-1/2% Argon, 2-1/2% CO<sub>2</sub>
- Spray Transfer: 95-98% Argon, 2-5% CO<sub>2</sub>
- Spray Transfer: 98-99% Argon, 1-2% O<sub>2</sub>
- Flow rate: 35-50 CFH

## Applications

- Agricultural Equipment
- Auto Body
- Automotive Exhaust
- General Fabrication
- Heavy Equipment
- Pipe Welding
- Pressure Vessels
- Railcars
- Shipbuilding
- Structures
- Trailers

## Specifications

Meets or Exceeds:

- AWS A5.9/A5.9M: ER309, ER309L
- ASME SFA-A5.9: ER309, ER309L
- ASME Section III Nuclear requirements

## Storage

Welding wire should be stored in a dry, enclosed environment and in its originally sealed package.

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## Stainless Steel Filler Metals for Welding Dissimilar Metals

201,202, 301,302, 302B,303, 304,305,308	304L	309, 309S	310, 310S, 314	316	316L	317	317L	321, 347, 348	330	403,405, 410,414, 416,420	430,430F, 431,440A, 440B,440C	448	501, 502	505	CARBON STEEL	CR-MO STEEL
		309	309	309	309	309	309	309	309	309	309	310	309	309	309	309

## Typical Wire Chemistry Percentages (as required per AWS)

ASME SFA 5.9	AWS A5.9/ AWS A5.9M	Carbon	Cr	Ni	Mn	Si	OTHER
Yes	Yes	0.03 Max	23.00/25.00	12.00/14.00	1.60/2.50	0.45/0.65	



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