

Classifications

EN ISO 14343-A

AWS A5.9 / SFA-5.9

S 22 12 H

ER309 (mod.)

Characteristics and typical fields of application

Solid wire for submerged arc welding for joining and surfacing applications with matching/similar heat resistant steels and cast steel grades.

Typical analysis of the wire

	C	Si	Mn	Cr	Ni
wt.-%	0.10	0.90	1.5	22.5	11.5

Typical fluxes to combine

Process	Name	EN ISO 14174
SAW	Marathon 104	S A FB 2 AC

Packaging

Size(s) in mm	Type	Weight
2,4	basket spool	25 kg

Other sizes and coil weights on request.

