

WELDSKILL 309L

PRODUCT DATA SHEET



E309L-16 TYPE STAINLESS STEEL ELECTRODE

45
OCV

AC
DC+

WELDSKILL WELDING ELECTRODES & WELDING WIRES

WELDSKILL 309L

- E309L-16 type stainless steel electrode.
- Designed for fillet & butt welding in all positions except vertical-down.
- Smooth running electrode with low spatter levels.
- Ideal for welding of matching 309 & 309L grades of stainless steel & dissimilar steels.
- Also suitable as an intermediate buffer layer prior to hardfacing or as a stainless steel overlay on mild steel.
- Packed in resealable plastic tubes.

CLASSIFICATIONS:

ISO AS/NZS 4854:	ES309L-16
AWS A5.4:	E309L-16

TYPICAL MECHANICAL PROPERTIES:

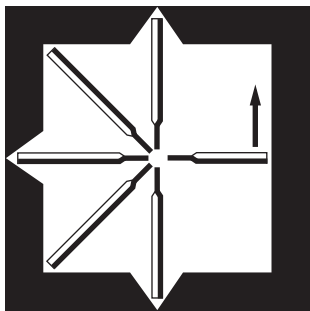
Yield Stress	510 MPa
Tensile Strength	620 MPa
Elongation	36%
CVN Impact Values	60 J av @ +20°C

TYPICAL ALL WELD METAL ANALYSIS:

C:	0.03%
Cr:	22.8%
Mn:	0.75%
Ni:	13.2%
Si:	0.8%

WELDING POSITIONS:

All positional - except vertical down.



PACKAGING & OPERATING DATA:

AC (minimum 45 O.C.V.), DC+ or DC- polarity.

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	APPROX NO. RODS/KG	CURRENT RANGE (AMPS)	PACK SIZE	CARTON	PART NO.
2.5	300	50	40-90	1.7kg	10.2kg - 6 x 1.7kg	WES309225N
3.2	350	27	60-120	2kg	12kg - 6 x 2kg	WES309232N

