

## WELDSKILL 309L

45  
OCV

AC  
DC+

- 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

### TYPICAL MECHANICAL PROPERTIES:

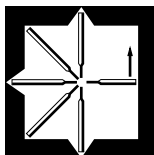
Yield Stress	510 MPa
Tensile Strength	620 MPa
Elongation	36%
CVN Impact Values	60J av @ +20°C

### TYPICAL ALL WELD METAL ANALYSIS:

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

### Classifications:

AS/NZS 1553.3: (old)	E309L-16
AS/NZS 4854: (new)	ES309L-16
AWS A5.4:	E309L-16



All positions except vertical down

### Packaging and 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	46	40-70	1kg	12kg - 12 x 1kg	WES309125
				2.5kg	15kg - 6 x 2.5kg	WES309225
3.2	350	28	75-110	1kg	12kg - 12 x 1kg	WES309132
				2.5kg	15kg - 6 x 2.5kg	WES309232
4.0	350	18	110-150	2.5kg	15kg - 6 x 2.5kg	WES309240