

E309L-16

AWS A5.4 E309L-16

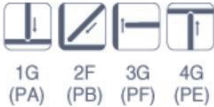
ISO3581-A-E23 12 R

GB/T 983 E309L-16

Description:

A super-low carbon stainless steel electrode designed to weld Cr23Ni13 and similar composition type steels, the carbon content of its deposit metal is $\leq 0.04\%$. With excellent operation and processing properties. Its weld metal with excellent corrosion and pores resistance performance. Used to weld similar composition steels, clad steels and dissimilar steels for the manufacture of petrochemical equipment.

Welding Position:



Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

| | |
|------------------------|-----|
| Tensile strength(MPa): | 580 |
| Yield strength(MPa): | -- |
| Elongation(%): | 40 |

Typical Chemical Compositon:

| C | Mn | P | S | Si | Ni | Cr | Mo | Cu |
|-------|------|-------|-------|-------|------|------|------|-------|
| 0.021 | 0.92 | 0.012 | 0.003 | 0.630 | 12.9 | 24.1 | 0.12 | 0.009 |

Welding Current:(AC/DC±)

| Diameter(mm) | 2,5 | 3,2 | 4,0 | 5,0 |
|--------------|------------|--------|---------|---------|
| Current/A | F/H 60-80 | 80-120 | 100-150 | 140-180 |
| Current/A | V/OH 40-70 | 60-100 | 80-130 | - |

Note:

- 1.The electrodes should be baked 1 hours in 300-350℃ before using.
- 2.Welding in short arc,and swing scope should not excess 2.5 times of the electrode diameter.