

**SMAW****For Stainless Steel****STAINARC 309L**

CLASSIFICATION : AWS A5.4 E309L-16

JIS Z3221 D309L-16

WELDING POSITIONS :



- All Positional, Rutile Type Stainless Steel Electrode
- Moisture Resistance Flux Coating
- Improved Slag Lift
- Suitable For The Dissimilar Welding Of Stainless Steel To Mild / Low Alloys Steels

**DESCRIPTION AND APPLICATIONS**

STAINARC 309L is an extra low carbon, rutile type electrode exhibiting superior all positional (except vertical down) performance for weld metal of high radiographic integrity. The smooth arc action of STAINARC 309L together with low spatter and excellent slag control/detachability promote exceptional weld appearance.

STAINARC 309L is a highly alloyed 22% Cr / 12% Ni stainless steel electrode for welding 309 and 309L base metals. A major application is the welding of a wide range of 300 and 400 series stainless steel to mild / low alloy steels giving strong tough welds. STAINARC 309L is also suitable for general welding applications involving alloyed and unalloyed dissimilar ferrous metals.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)					
C	Mn	Si	Cr	Ni	Fe
0.03	1.34	0.71	23.78	12.58	Bal

FERRITE NUMBER
<b>15.0 - 20.0 FN*</b>
* using Sevens Gauge

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES•			
YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
400 N/mm <sup>2</sup>	630 N/mm <sup>2</sup>	37%	-

- in "as welded" condition.

OPERATIONAL AND PACKAGING DATA					
ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE • (amps)	PACKAGING (kg)		
			PKT	CTN	
2.6	300	50 - 75	2.5	5	20
3.2	350	75 - 110	2.5	5	20
4.0	350	110 - 150	2.5	5	20

- Recommended for DC+ or AC (minimum 70 OCV) operation

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