

Stainless Steel SMAW Electrodes

KE309L

AWS A5.4 E309L-16
JIS Z 3221 ES309L-16

Product Features:

- All deposited weld metal contains approximately 23%Cr-13%Ni elements type covered electrode for low carbon content stainless steel.
- Austenite weld metal contains adequate ferrite numbers to provide low crack sensitivity.
- Good heat and corrosion resistance.

Applications:

- Welding of SUS 309L stainless steel.
- Welding of Carbon steel or other high hardening alloy steels to stainless steel (low carbon).
- Cladding or welding of stainless steel (low carbon) to carbon steel or low alloy steel.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr
0.03	0.72	1.2	13.40	23.70

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
570	39

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.0/250	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	40~60	60~85	85~120	115~150	150~200
Vertical / overhead position	----	50~75	75~105	95~120	----

Note:

ecoweld®

CMI

50 Toegye-ro 18-gil, Jung-gu
Seoul, South Korea
www.ecoweldkorea.com