

Stainless Steel SMAW Electrodes

G309L

AWS A5.4 E309L-16
JIS Z 3221 ES309L-16
ISO 3581-A-E 23 12 L R 12

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	Fe
0.03	0.72	1.05	13.61	24.15	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
509	591	45

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

Diameter / Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	60~85	85~120	115~150	150~200
Vertical / overhead position	50~70	75~105	95~130	----

Note:

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