

SUNWELD 309L

Stainless Steel Electrode



CLASSIFICATION

AWS A 5.4 : E 309L 16

IS 5206-83 : E23.12 LR 26

CHARACTERISTICS

SUNWELD 309L-16 is a stainless steel electrode depositing an extra low carbon 24 Cr – 12 Ni weld metal which has excellent mechanical properties and posses good oxidation and scaling resistance at elevated temperatures. The weld metal is of radiographic quality.

Special Characteristic: Delta Ferrite 5 to 10 FN

APPLICATIONS

Ideally suited for welding stainless steels, wrought and cast materials of similar composition, welding of 18/8 type stainless steels to carbon steels for buffer layers, for welding lad side of 18/8 clad stainless etc. It is specially use full for joining stainless to mild steel, stainless steel to low alloy steels.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

C	Mn	Si	Cr	Ni	S	P
0.032	1.30	0.47	23.90	12.90	0.014	0.018

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Ultimate Tensile Strength	Elongation
594.0 N/mm ²	38.0 %

CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
2.50	350	60-80	2 Kg	10 Kg
3.15	450	80-100	2 Kg	10 Kg
4.00	450	100-140	2 Kg	10 Kg
5.00	450	140-180	2 Kg	10 Kg

RECOMMENDATIONS:

Re-dry the electrodes at 200°C for one hour. Use stainless steel wire brush for cleaning the welds.