

E 309L-17

STAINLESS STEEL STICK WELDING ELECTRODE

Classification : AWS: A 5.4 E 309L-17

Description : An extra low carbon, all position giving 24Cr and 12Ni deposit with excellent resistant to chemical corrosion and heat resistant, welding suitable similar stainless steel and dissimilar metals such as stainless steel to mild steel or low alloy steel, clad steel side welding of low carbon 18%cr-8% Ni steel, gives stable arc, low spatter, smooth weld profile and easily removable slag,

Typical Application :

- Welding of 22% Cr – 12% Ni steel and other dissimilar metal
- Joining of stainless steel to mild or low alloy steel
- Build up application with low carbon content
- used in chemical industries, pulp-paper industries for welding pipes, tanks, plates

Re-Dry Condition : Re-Dry the electrode at 300°C for 1 hrs, for best results.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Cr	S	P	Mo	Cu
0.040	0.5 - 2.5	1.0	12 – 14	22 – 25	0.030	0.040	0.75	0.75

(Single value maximum)

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	Elongation %	CHARPY “V” NOTCH IMPACT AT
>400	520 min.	30 min.	+20 ⁰ C : 80 - 100 Joules

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/AC 70V)	kg/pkt.	kg/Case
2.50/2.40	3/32”	50-80	2	10
3.15/3.20	1/8”	70-120	2	10
4.00	5/32”	100-140	2	10
5.00	3/32”	140-180	2	10

Tailor made packing available on request.