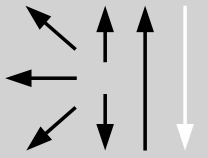


Classification				
AWS A5.4				
E309L-16				
Characteristics and typical fields of application				
Electrode designed for dissimilar welding between stainless steel and mild steel or low alloy steels. The electrode provides good all-round weldability with smooth bead surface.				
Base Materials				
Dissimilar joint welds between high strength, mild steels and low alloyed with stainless steels.				
Typical analysis of All Weld Metal (wt.-%)				
C	Si	Mn	Cr	Ni
0.03	0.85	0.60	23.0	12.5
Mechanical properties of all-weld metal				
Heat treatment	Yield strength R_e N/mm ²	Tensile strength R_m N/mm ²	Elongation ($L_0=5d_0$)	Impact work ISO-V KV J
	MPa	MPa	%	+20°C
As Welded	460	560	35	60
Operating data				
		Polarity DCEP / AC		
Interpass temperature : 150°C Heat Input: Max. 2.0 KJ/mm Re-drying: 300-350°C minimum 2 hours				
Size, Packaging and Electrical Operating Data				
Size mm	Kg / Pack	Kg / Box	Amperage (A)	
2.50 × 350	2.0	16.0	50 – 80	
3.25 × 350	2.0	16.0	60 – 120	
4.00 × 350	2.0	16.0	110 – 160	