

KS-309L

Classification

AWS A 5.4/A5.4M E309L-16

Type of coating: Lime titania type AS/NZS 4854 B ES309L-16

Applications and Features

- (1) Weld metal is low carbon 24%Cr-13%Ni.
- (2) Excellent crack resistance due to low carbon and more ferrite.
- (3) It is suitable for welding low carbon stainless steel and low carbon cladding, AISI 309S, heat resistant steel (13Cr, 18Cr steel) or dissimilar metals.

Welding Position

All Position

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni
0.030	0.37	1.52	0.015	0.008	23.52	13.86

Typical Mechanical Properties of Weld Metal

Tensile Strength MPa	Yield Strength MPa	Elongation %
550	410	45

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)		2.6x300	3.2x350	4.0x350
Amp	F/H-Fillet	50~85	80~120	100~150
	V-up/OH	45~85	70~110	90~135

Diam.	Pack	Part No.
2.5mm	2.5kg Tube x 12 = 30 kg	KS30925
3.2mm	2.5kg Tube x 12 = 30 kg	KS30932
4.0mm	2.5kg Tube x 12 = 30 kg	KS30940

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