

Stick Electrode for Stainless steel

KS-309L-17

Classification

AWS A5.4/A5.4M	E309L-17
JIS Z3221	ES309L-17
EN ISO 3581-A	-
GB T983	E309L-17

Coating Type : Lime Titania

Applications and Features

- (1) Weld metal is austenitic structure with 22%Cr-12%Ni.
- (2) Suitable for dissimilar joints welding in stainless steel and carbon steel, the SUS 304 composite steel overlay bottom welding.

Welding Position



Welding Instruction

- (1) Please refer to Appendix A.
- (2) Please refer to Appendix F.

Typical Weld Metal Composition (wt%)

C	Si	Mn	P	S	Cr	Ni
0.02	0.83	0.85	0.027	0.013	23.26	13.88

Typical Weld Metal Mechanical Properties

Tensile strength	Yield strength	Elongation
N/mm ²	N/mm ²	%
603	432	42

Available Sizes and Welding Parameters (AC or DC+)

Diameter (mm)	2.6	3.2	4.0	5.0
Current (A)	F/HF	50~85	80~120	100~150
	V-up/OH	45~80	70~110	90~135
				140~180
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