



## EI 309L

Coated Electrode for Stainless Steels -

### Standards

AWS/ASME SFA - 5.4	E309L-16
EN ISO 3581 - A	E 23 12 L R 12
TS EN ISO 3581 - A	E 23 12 L R 12

### Approvals & Certificates

<b>BV</b>	<b>CWB</b>	<b>DB</b>
<b>DNV-GL</b>	<b>TSE</b>	<b>TUV</b>
<b>CE</b>		

### Properties and Applications

Electrode for joining dissimilar steels (austenitic steels to ferritic steels) and for austenitic claddings on ferritic steels. Weld metal consists of austenite with approx. 15% delta-ferrite. Claddings on unalloyed and low alloy steels are already corrosion resistant in the first layer. Higher operating temperature for joints between dissimilar steels is +300°C. In case of higher temperatures use ENI 422 electrodes. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easy slag removal, easy arc striking and restriking.

### Typical Chemical Values of Weld Metal

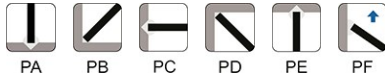
Type of Analysis	C	Si	Mn	Cr	Ni
Weld Deposit	0.03	0.9	1.10	23	12.65

### Typical Mechanical Values of Weld Metal

Test Condition	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	570	35	20°C → 60

### Application Information

#### Welding Positions



#### Polarity:



#### Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x250	50-80
2.50x300	50-80
3.25x300	80-120
3.25x350	80-120
4.00x350	100-165
5.00x350	140-220

### Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
13008FIEM1	2.50x250	80 AD	1.24	9	11.30	VAC Box
13008GDEM1	2.50x300	130 AD	2.60	3	7.90	Plastic Box
13008GDEM2	2.50x300	137 AD	2.62	3	8.00	Plastic Box
13008GIEM1	2.50x300	90 AD	1.70	9	15.50	VAC Box
13008GJEM2	2.50x300	96 AD	1.79	9	16.30	VAC Box
13008MDEM2	3.25x300	81 AD	2.62	3	8.00	Plastic Box
13008MEEM2	3.25x300	129 AD	4.21	3	12.80	Plastic Box
13008MIEM1	3.25x300	50 AD	1.60	9	14.60	VAC Box



13008MJEM2	3.25x300	57 AD	1.79	9	16.30	VAC Box
13008NDEM2	3.25x350	67 AD	2.64	3	8.10	Plastic Box
13008NEEM2	3.25x350	134 AD	5.21	3	15.80	Plastic Box
13008NJEM1	3.25x350	60 AD	2.30	9	20.90	VAC Box
13008NJEM2	3.25x350	54 AD	2.04	9	18.60	VAC Box
13008QEEM2	4.00x350	92 AD	5.21	3	15.80	Plastic Box
13008QJEM1	4.00x350	35 AD	1.97	9	17.90	VAC Box
13008QJEM2	4.00x350	37 AD	2.04	9	18.60	VAC Box
13008TEEM2	5.00x350	58 AD	5.21	3	15.80	Plastic Box
13008TJEM1	5.00x350	25 AD	2.22	9	20.20	VAC Box
13008TJEM2	5.00x350	23 AD	2.04	9	18.60	VAC Box

#### Storage & Re-Drying Information

It can be dried maximum 5 times.  
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.  
It has to be dried at 350°C for 2 hours.



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## CONTACT

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