

S-309L.15

Type : Basic

Conformances

AWS A5.4/ ASME SFA5.4 E309L-15

JIS Z3221 ES309L-15

EN ISO 3581-A-E 23 12 L B

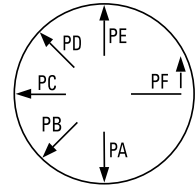
Applications

- Welding of dissimilar steels
- Buffer layer for build-up

Features

- Good resistance to heat and corrosion
- Good crack resistance
- Easy to remove slag

Welding Position



Current

DC +

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter	Length	P.V.C	
		packet	carton
mm (in)	mm (in)	2.5kg(5.5lbs)	10kg(22lbs)
2.6 (3/32)	300 (12)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni
0.03	0.60	1.25	0.015	0.010	23.5	13.0

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
610 (88,500)	40

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	300 (12)	350 (14)	400 (16)	400 (16)
F & HF	25-55	50-85	70-115	95-145	135-180
V-up, OH	20-50	45-80	65-110	85-135	-

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX