

# S-309L.16[17]

Type : Rutile, Rutile-acid



## Conformances

AWS A5.4/ ASME SFA5.4 E309L-16  
 JIS Z3221 ES309L-16 / EN ISO 3581-A-E 23 12 L R  
 AWS A5.4 / ASME SFA5.4 E309L-17  
 JIS Z3221 ES309L-17 / EN ISO 3581-A-E 23 12 L R  
 KR RD309L  
 ABS AWS A5.4 E309L-16  
 AWS A5.4 E309L-17  
 LR SS/CMn  
 BV UP

DNV-GL VL 309L  
 NK KD309L  
 CWB CSA W48 E309L-16  
 TÜV EN ISO 3581-A-E 23 12 L R  
 DB DIN EN ISO 3581-A-E 23 12 L R  
 CE  
 CCS 309L

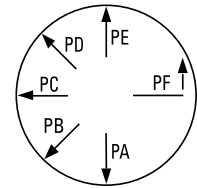
## Applications

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

## Features

- Good resistance to heat and corrosion
- Good crack resistance
- Easy to remove slag
- High moisture resistance (17 type)

## Welding Position



## Current

AC or DC ±

## Redrying Conditions

350°C (662°F) X 1hr

## Diameter / Packaging

Diameter	Length	Standard		Vacuum				P.V.C	
		packet	carton	packet	carton	packet	carton	packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)	1.5kg(3.3lbs)	15kg(3.3lbs)	5kg(11lbs)	20kg(44lbs)	2.5kg(11lbs)	10kg(22lbs)
2.0 (5/64)	300 (12)								✓
2.6 (3/32)	300 (12)								✓
3.2 (1/8)	350 (14)								✓
4.0 (5/32)	350 (14)								✓
5.0 (3/16)	350 (14)								✓

SMAW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX