

EI 309LRS

Coated Electrode for Stainless Steels -

Standards

AWS/ASME SFA - 5.4	E309L-17
EN ISO 3581 - A	E 23 12 L R 12
TS EN ISO 3581 - A	E 23 12 L R 12
DIN M. No.	1.4332

Properties and Applications

Rutile type 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. Fine metal droplet transfer, good fusion of joint faces, finely rippled flat and smooth bead surface, especially in fillet welds. Easy slag removal of slag.



Typical Chemical Values of Weld Metal

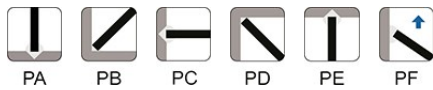
Type of Analysis	C	Si	Mn	Cr	Ni
Weld Deposit	0.03	0.90	1.10	23.00	12.50

Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	450	570	40	20°C → 60

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

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

Packaging Information

Product Code	Diameter X Length (mm)	Pieces per Box (~)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
13030GJEM2	2.50x300	96 kg	1.8	10	18.2	VAC Box
13030NJEM2	3.25x350	54 kg	2.0	10	18.6	VAC Box
13030QJEM2	4.00x350	37 kg	2.0	10	21.0	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
It has to be dried at 350°C for 2 hours.