

**SMAW**

CLASSIFICATIONS: AWS A5.4 : E309L-16  
 EN ISO 3581-A : E 23 12 L R 12  
 EN ISO 3581-B : ES309L-16  
 JIS Z 3221 : ES309L-16

# AceWeld 309L-16

For Stainless Steel

WELDING  
POSITIONS :



- **All Position, Rutile Type Stainless Steel Electrode**
- **Low Moisture Pick-up Type Coating**
- **Minimal Spatter and Self-peeling Slag**

## DESCRIPTION AND APPLICATIONS

**AceWeld 309L-16** is an extra low carbon Rutile type austenitic stainless steel electrode suitable for all positional (except vertical down) performance and can use for dissimilar metal welding (stainless steel to mild and low alloy steels).

Cladding on unalloyed and low alloy steels are corrosion resistance in the first layer. Other features include high arc stability, low spatter level, easy slag removed, low moisture absorption, easy striking and restriking even at low voltage AC welding machine.

## TYPICAL ALL WELD METAL COMPOSITION (Wt%)

| C    | Mn   | Si   | Cr   | Ni   | S     | P     |
|------|------|------|------|------|-------|-------|
| 0.03 | 0.90 | 0.90 | 23.8 | 12.8 | 0.012 | 0.025 |

## TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

| YIELD STRESS | TENSILE STRENGTH      | ELONGATION | CVN IMPACT VALUES |
|--------------|-----------------------|------------|-------------------|
|              | 570 N/mm <sup>2</sup> | 35%        | 70J @ +20°C       |

## OPERATIONAL AND PACKAGING DATA

| ELECTRODE SIZE (mm) | ELECTRODE LENGTH (mm) | WELDING CURRENT RANGE(amps.) | PACKAGING (KG) |     |
|---------------------|-----------------------|------------------------------|----------------|-----|
|                     |                       |                              | PKT            | CTN |
| 2.0                 | 300                   | 35 - 45                      | 2.5            | 20  |
| 2.6                 | 300                   | 50 - 80                      | 2.5            | 20  |
| 3.2                 | 350                   | 70 - 100                     | 2.5            | 20  |
| 4.0                 | 350                   | 100 - 150                    | 2.5            | 20  |
| 5.0                 | 350                   | 140 - 190                    | 2.5            | 20  |

- Recommended for DC+ or AC (minimum 70 OCV) operation.
- Available in 1 KG packaging.
- Re-dry electrode at 300°C - 350°C for 1 hour if necessary
- Also available in: Solid Mig Wire : MIG MC-309LSi, Tig Rod : TIG MC-309L, Flux Cored Wire : COREMAX 309LP