

SMAW

AceWeld 309L-17

For Stainless Steel

CLASSIFICATIONS: AWS A5.4 : E309L-17
 EN ISO 3581-A : E 23 12 L R 12
 EN ISO 3581-B : ES309L-17
 JIS Z 3221 : ES309L-17

WELDING
POSITIONS :



- **All Position, Rutile Silica Type Stainless Steel Electrode**
- **Low Moisture Pick-up Type Coating**
- **Allow Much Higher Welding Currents Than L-16 Electrode**

DESCRIPTION AND APPLICATIONS

AceWeld 309L-17 is an low carbon Rutile silica type stainless steel electrode for joining dissimilar steels such as Cr-Mo steel or carbon steel to stainless steel. This electrode used for universal repair in maintenance as it is highly crack resistant .

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 and allow higher welding currents than L-16 type electrode.

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	0.020

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
	600 N/mm ²	>34%	65J @ 20°C

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE(amps.)	PACKAGING (KG)	
			PKT	CTN
2.0	300	40 - 50	2.5	20
2.6	300	55 - 85	2.5	20
3.2	350	80 - 120	2.5	20
4.0	350	110 - 150	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