

## SB ZULFI E 309L-15

### Brand Name & Classification

AWS/ASME SFA-5.4:E 309L-15  
DIN 8556: E 23 12 LB 20

### Approvals Grade

### Properties

Austenitic stainless steel electrode suitable for welding dissimilar steels (austenitic steels to ferritic steels) and for depositing austenitic claddings. Weld metal consists of approximately 15% delta ferrite.

### Application

Joining of unalloyed and low-alloyed steels to stainless/heat resistant steels (wrought and cast types), stainless claddings on mild steels

### Weld Metal Analysis Typical values

Carbon: 0.03

Silicon: 0.80

Manganese: 0.70

Chromium: 24.0

Nickel: 13.0

### Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>400 N/MM2	520 - 580 N/mm2	> 30 %	60 J at +20 <sup>0</sup> c

### Welding Current & Positions



### Current

Dia	Length	Amperes
2.5	300	45-80
3.2	350	70-120
4.0	350	100-150