

SR ZULFI E 309L-16

Brand Name & Classification

AWS/ASME SFA-5.4: E 309L-16

DIN 8556: E 23 12 LR 23

Approvals Grade

Properties

Austenitic stainless steel electrode suitable for welding dissimilar steels and for depositing austenitic claddings. Weld metal consists of approximately 15% delta ferrite. Highest operating temperatures for dissimilar steel joints is +300⁰ c.

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 ⁰ c

Welding Current & Positions



Current

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