

Exaton 309/309L

309/309L is a chromium-nickel strip electrode used for submerged arc welding (SAW) and high speed electro-slag welding (ESW) to deposit a buffer overlay of corrosion resistant alloy of 19%Cr/9%Ni composition on carbon- and low alloyed steels. It is combined with 308L for surfacing of two layer overlays.

Specifications	
Classifications	EN ISO 14343-A : B 23 12 L SFA/AWS A5.9 : EQ309L
Approvals	CE : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Ferrite FN
<=0.015	1.8	0.35	<=0.015	<=0.015	13	23.5	<=0.3	<=0.1	15