

Sureweld 309L

Sureweld 309L electrodes produce a concave bead with smooth ripples and a self-releasing slag. For welding dissimilar carbon steel to stainless steel or to weld 22% Cr - 12% Ni stainless steels for service below about 315°C (600°F) and for the first layer when cladding.

Specifications

Classifications	ASME SFA 5.4 AWS A5.4 : E309-16/E309L-16
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	>450 MPa (65 ksi)	>520 MPa (75 ksi)	30 %

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Cu
0.03	0.62	0.70	13.25	23.3	0.1	0.1