

Arcaloy 309L-15

Arcaloy 309L-15 is used for welding carbon and low alloy steels to stainless steels. This can be done provided the service temperature does not exceed about 700° F (370°). Post weld heat treatment should only be taken with great care. Arcaloy 309L-15 can be used as the first layer of stainless steel on carbon or low alloy steel.

Specifications

Classifications	ASME II SFA A5.4 : E309L-15/E309-15 ASME IX : F No. 5 AWS A5.4 : E309L-15/E309-15
Approvals	QPL

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

Alloy Type	309L-15
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	415 MPa (60 ksi)	590 MPa (86 ksi)	45 %

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Cu	Ferrite FN
0.035	1.8	0.5	13.5	24	0.3	0.1	9