

Arcaloy 309L-17 Plus

Arcaloy 309L-17 Plus electrodes have a heavy coating and produce a concave bead with minimal ripple. The slag is virtually self-cleaning. For welding carbon steel to stainless steel for service below about 315°C (600°F) and for the first layer when cladding.

Specifications

Classifications	ASME II SFA A5.4 : E309L-17/E309-17 ASME IX : F No. 5 AWS A5.4 : E309L-17/E309-17
Approvals	CWB : E309L-17

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

Alloy Type	309L-17 Plus
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	450 MPa (65 ksi)	590 MPa (86 ksi)	37 %

Typical Weld Metal Analysis %

Recommended Welding Parameters

Wire Diameter	Flat Amps	Vertical Amps	Overhead Amps
2.4 mm (3/32 in.)	60-85 A	35-50 A	40-60 A
3.2 mm (1/8 in.)	90-120 A	55-70 A	60-85 A
4.0 mm (5/32 in.)	140-165 A	85-100 A	95-120 A