

Limarosta 309S

Key Features

- All positional Electrode (except vertical down) suitable for welding 300 series stainless steel and C-Mn to Stainless steel dissimilar welds
- Excellent wetting characteristics
- High resistance to porosity

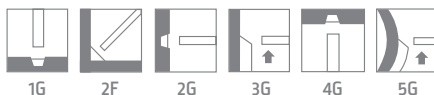
Typical Applications

- Dissimilar welding
- Cladding
- Butter layer

Conformances

AWS A5.4: E309L-17
AS/NZS 4854-A: E 23 12 L R 22

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	557534-1	CB 2.0 kg (6 x CB per carton)
3.2	350	557565-1	CB 4.2 kg (3 x CB per carton)
4.0	450	557589-1	CB 5.6 kg (3 x CB per carton)

Mechanical Properties

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ +20°C
Requirements - AWS	-	520 min	30 min	-
Requirements - AS/NZS	320 min	510 min	25 min	-
Typical Results - As Welded	440	580	35	50

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.03	0.9	1.0	0.025	0.01
	%Ni	%Cr	FN (acc.WRC 1992)		
Typical Results - As Welded	12.5	23.0	8-15		

Typical Operation Procedures

Polarity	Current (amps)		
	2.5mm	3.2mm	4.0mm
DC+	70-90	100-120	140-160