

## Stick electrode

**Features:** • Suitable for dissimilar-metal joint and underlaying on ferritic steels

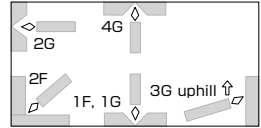
**Classification:** AWS A5.4 E309L-16

**Redrying Conditions:** 150~200°Cx0.5~1h

**Identification color:** 1st Yellow green, 2nd Blue white

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.0	250	2	20	11	300W, 125H, 280L
2.6	300	2	20	20	300W, 95H, 330L
3.2	350	5	20	36	175W, 125H, 380L
4.0	350	5	20	55	175W, 115H, 380L
5.0	350	5	20	82	175W, 115H, 380L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.04	0.04
<b>Si</b>	0.42	1.00
<b>Mn</b>	1.6	0.5~2.5
<b>P</b>	0.03	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	13.3	12.0~14.0
<b>Cr</b>	23.8	22.0~25.0
<b>Mo</b>	0.18	0.75
<b>Cu</b>	0.09	0.75

Note: <sup>a</sup>Single values are maximum.

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.0	50~75	45~65
2.6	75~95	70~90
3.2	85~120	80~115
4.0	110~160	90~140
5.0	150~200	-

## All-weld mechanical properties

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	410	-
<b>TS (MPa)</b>	560	518min.
<b>El on 4d (%)</b>	42	30min.
<b>IV 0°C (J)</b>	67	-

## Approvals

<b>LR</b>	SS/CMn m (Chem.)
<b>DNV</b>	309L
<b>BV</b>	UP (E309L-16)
<b>NK</b>	KD309L
<b>TÜV</b>	EN ISO 3581-A-E 23 12 L R